

FIG. 1

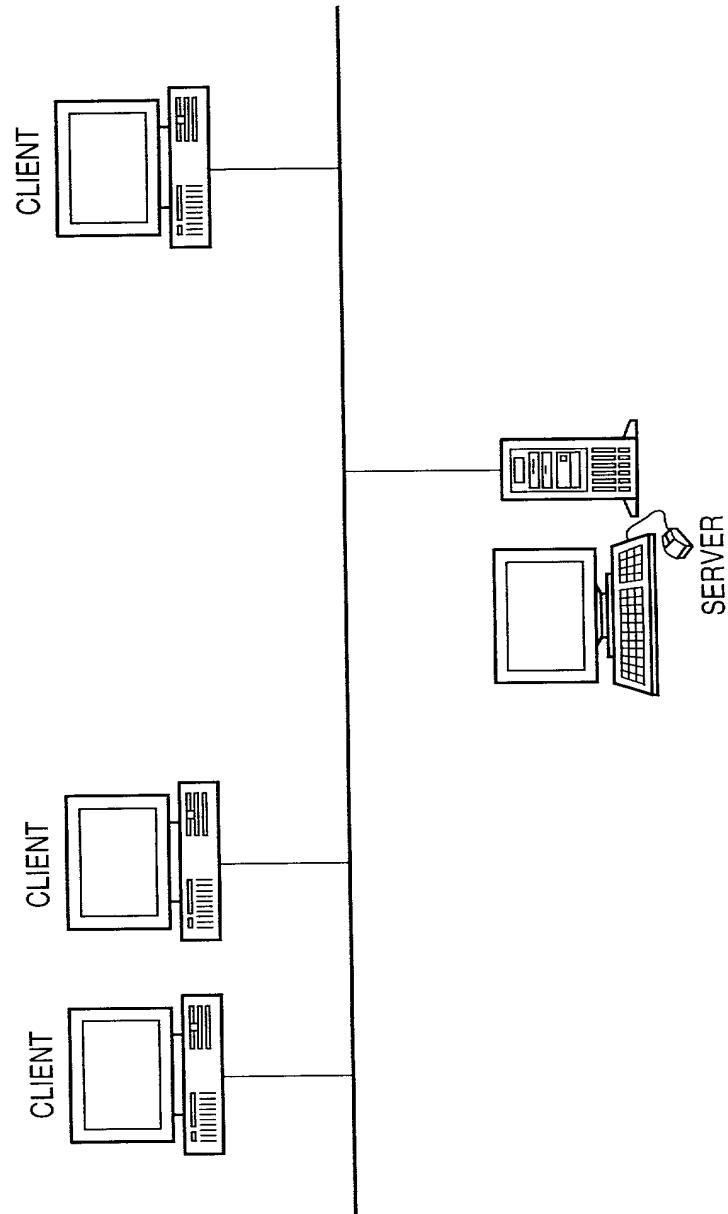
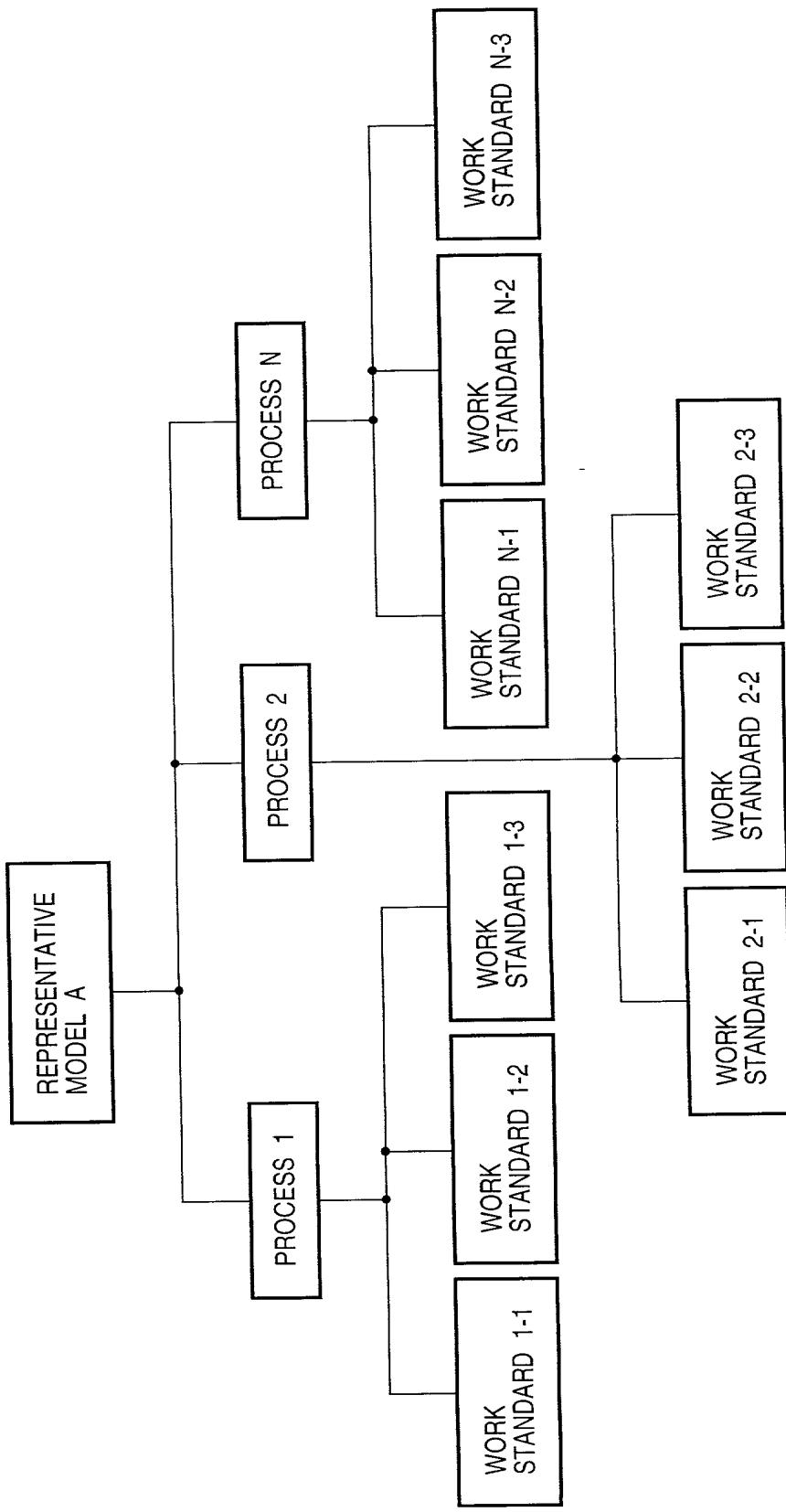


FIG. 2



3  
FIG.

302

WORK STANDARD 01 CREATION

301 APPLIED

卷之三

PART NUMBER

300 301

卷之三

TOOL / TIME

111

111

— 1 —

WORK PBC

111

310

309

REVISION NUMBER	CONTENTS OF REVISION	DATE	PERSON IN CHARGE	APPROVE	WORK NAME	MANAGEMENT NO.
01	CREATED	1997/09/25				

104

REVISION NUMBER 01  
CREATED 01/01/2010

四

MANAGEMENT NO. ▶

111

卷之三

卷之三

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3  
1  
3

312

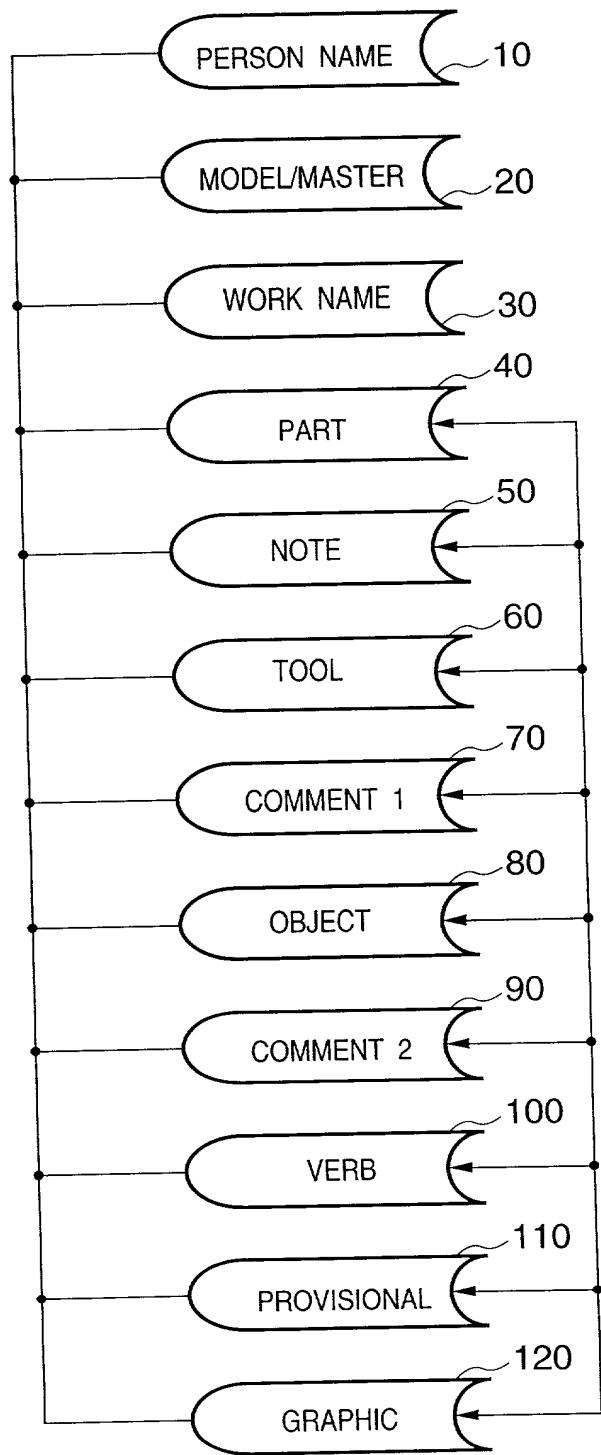
300

110

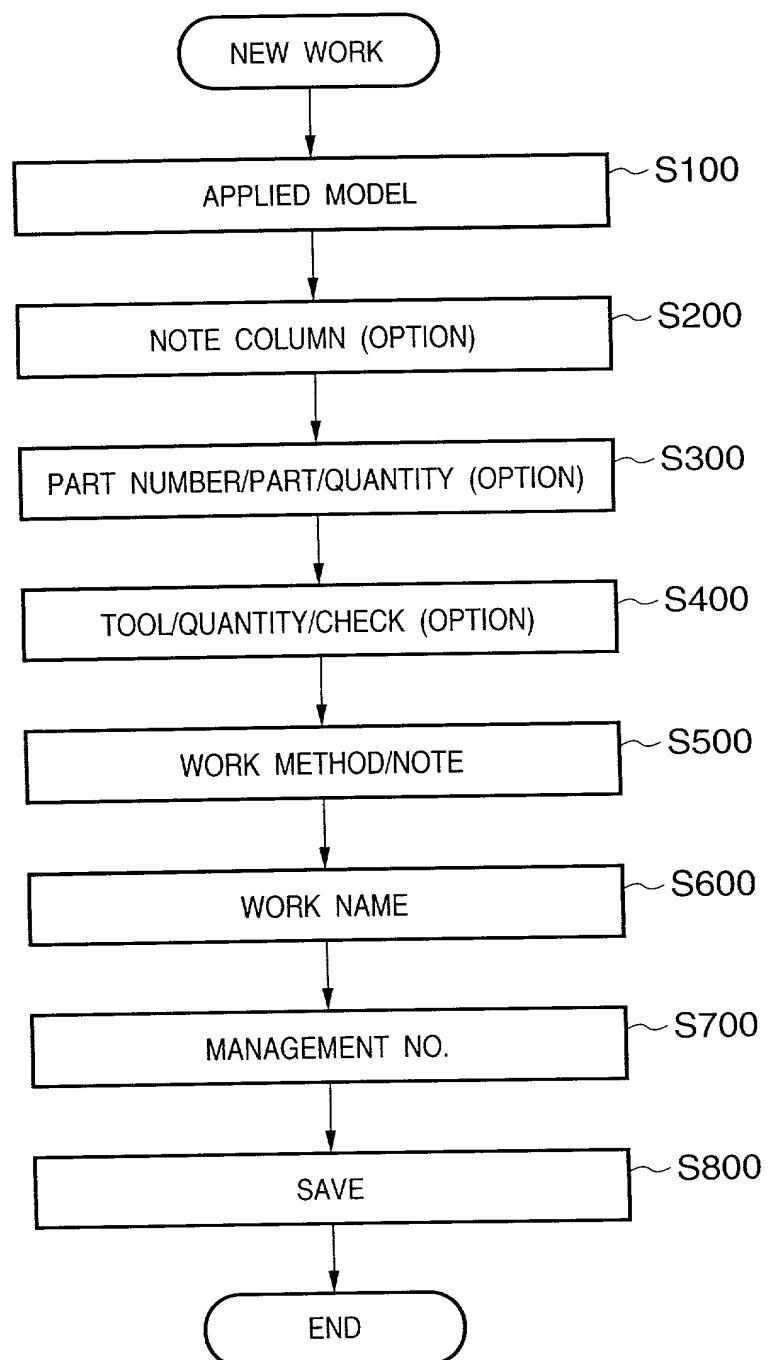
1

## FIG. 4

## STRUCTURE OF MASTER FILE



## FIG. 5



## FIG. 6

SELECTION OF APPLIED MODEL	
LIST OF APPLIED MODELS	
BJC-4200 SYSTEM	
BJC-420J	
BJC-420J (BLACK)	
BJC-4300	
BJC-430J	
BJC-4200LX	
A250 II Q	
BJC-4200	
OK	CANCEL

FIG. 7

WORK STANDARD 01 CREATION		<input type="checkbox"/> <input checked="" type="checkbox"/> X	
<b>APPLIED</b> BJC-420J BJC-420J(BLACK) BJC-430J			
PART NUMBER	PART NAME	QUANTITY	PART NUMBER
			PART NAME
			QUANTITY
			▲

## FIG. 8

PART NUMBER	PART NAME	QUANTITY	PART NUMBER
PART			
000 - 0000 - 001	PART 001		▲
000 - 0000 - 002	PART 002		
000 - 0000 - 003	PART 003		
001 - 0000 - 001	PART 101		
001 - 0000 - 002	PART 102		
111 - 1111 - 001	PART 001		
A01 - 1234 - 001	TEST PART 0001		▼

## FIG. 9

- WORK NAME
- CANDIDATES

原稿(GENKO)ガラス保護紙セット(SET ORIGINAL GLASS  
PROTECTIVE SHEET)

現像(GENZOU)レール戻しバネ掛け(HOOK DEVELOPING RAIL  
RETURN SPRING)

現像(GENZOU)レール戻しバネ掛け(後)(HOOK DEVELOPING  
RAIL RETURN SPRING(AFTER))

原稿(GENKOU)台ガラスセット(SET ORIGINAL GLASS TABLE)

原稿(GENKOU)台保護紙セット(SET ORIGINAL TABLE  
PROTECTIVE SHEET)

現像機(GENZOUKI)トナーなしチェック(CHECK NO TONER IN  
DEVELOPER)

現像機(GENZOUKI)エラーチェック(CHECK ERROR IN  
DEVELOPER)

現像機(GENZOUKI)ロック(LOCK DEVELOPER)

## FIG. 10

THE OUTLINE OF THE GENZOU

- WORK NAME
- CANDIDATES

現像(GENZOU)レール戻しバネ掛け(HOOK DEVELOPING RAIL RETURN SPRING)  
現像(GENZOU)レール戻しバネ掛け(後)(HOOK DEVELOPING RAIL RETURN SPRING(AFTER))  
現像機(GENZOUKI)トナーなしチェック(CHECK NO TONER IN DEVELOPER)  
現像機(GENZOUKI)エラーチェック(CHECK ERROR IN DEVELOPER)  
現像機(GENZOUKI)ロック(LOCK DEVELOPER)



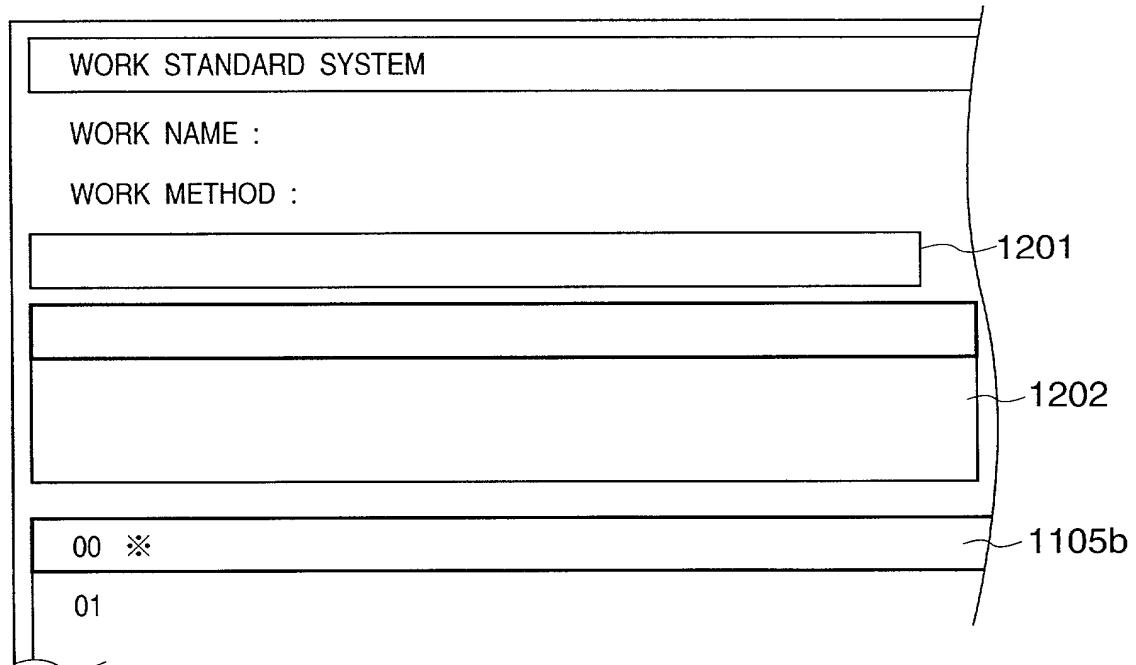
FIG. 11

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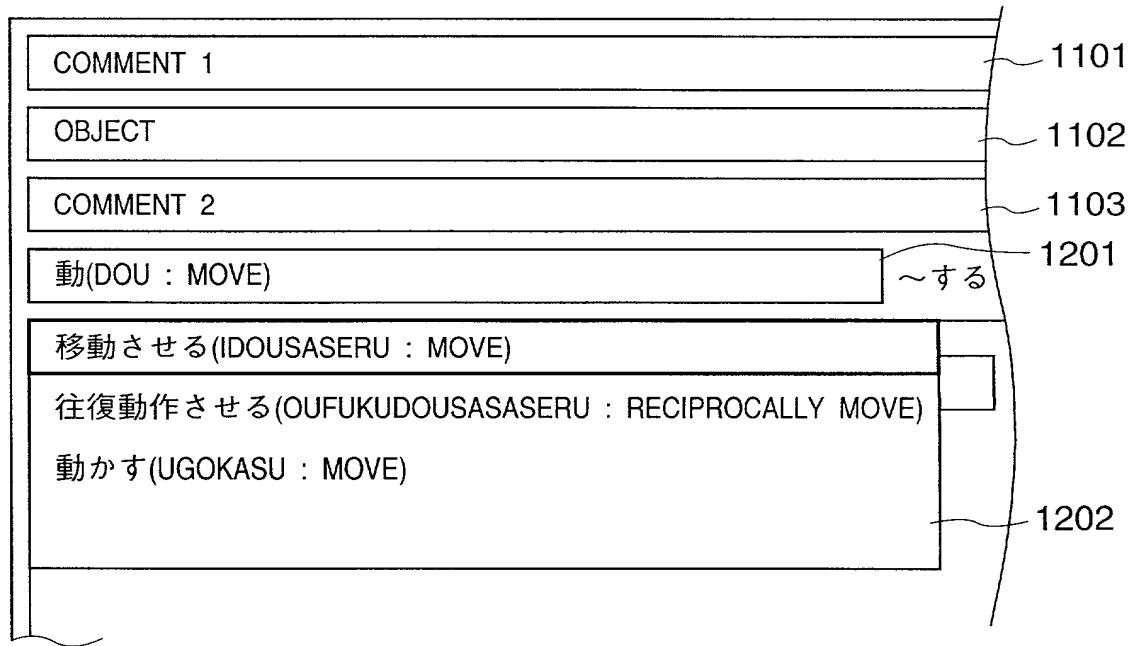
WORK STANDARD SYSTEM	
WORK NAME :	1100
WORK METHOD :	
1101	(COMMENT 1)
1102	(OBJECT) ~を
1103	(COMMENT 2)
1104	(VERB) ~する
00	※
01	
1105	
1105a	
1105b	
1106	
1107	
NOTE, STANDARD / REQUIRED QUALITY :	
1108	<input type="button" value="OK"/> <input type="button" value="CANCEL"/>

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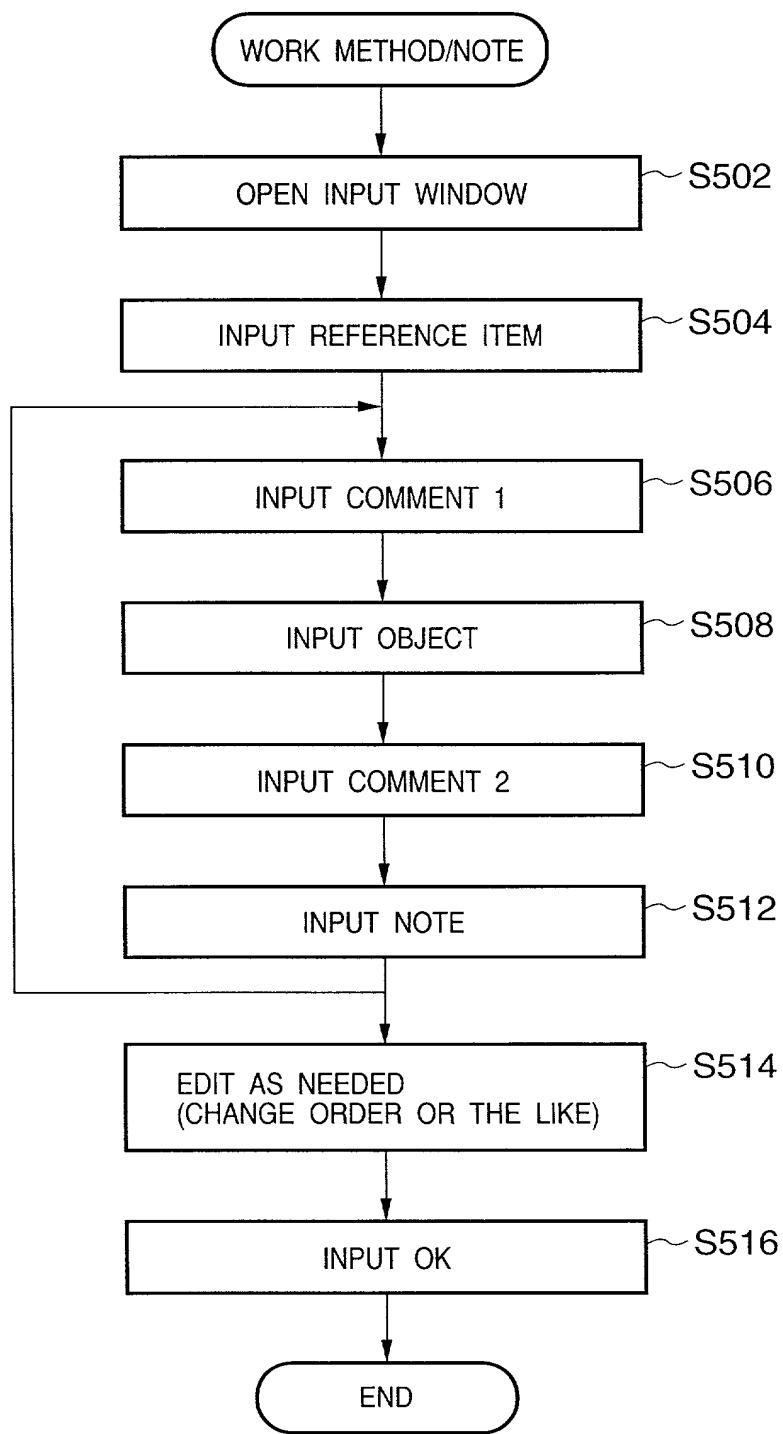
## FIG. 12



## FIG. 13



## FIG. 14



**FIG. 15**

00	※
01	DO zzzz SUCH THAT xxxx AT www POSITION BECOMES yyyy
02	WIND AV CORD
03	CONFIRM 100V SYSTEM
04	SET CRG HOLDER

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## FIG. 16

NOTE, STANDARD / REQUIRED QUALITY

NOTE

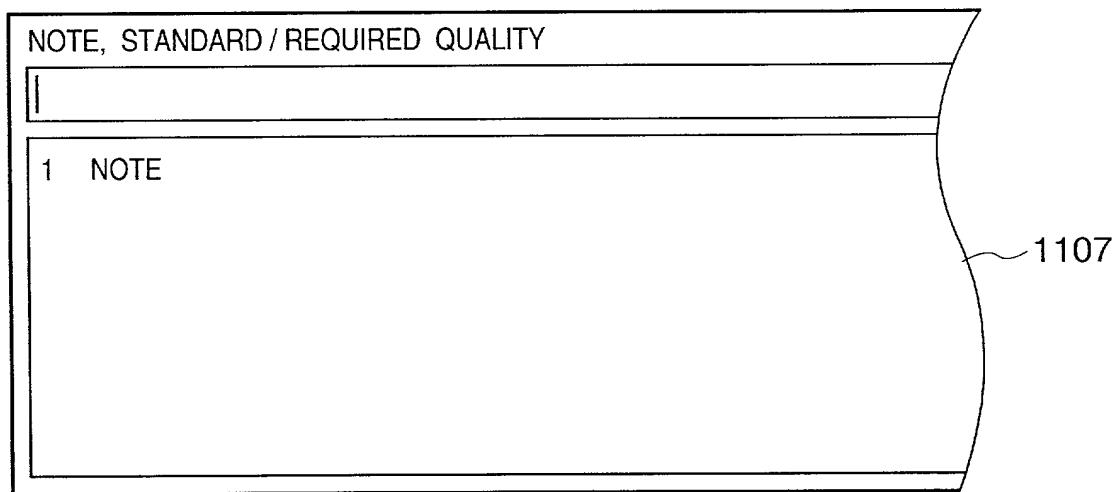
1601

SEPARATION GRIPPER MOVES SLOWLY WITHOUT GRIPPER SPRING OF ASFu  
DON'T PULL TAPE TOO STRONG TO MAKE SIDE GUIDE LOOSE  
DON'T HOOK PAPER GUIDE u ON SHEET HOLDER  
BEWARE OF IMITATIONS  
BEWARE OF IMITATIONS(Color Style Write)

1602

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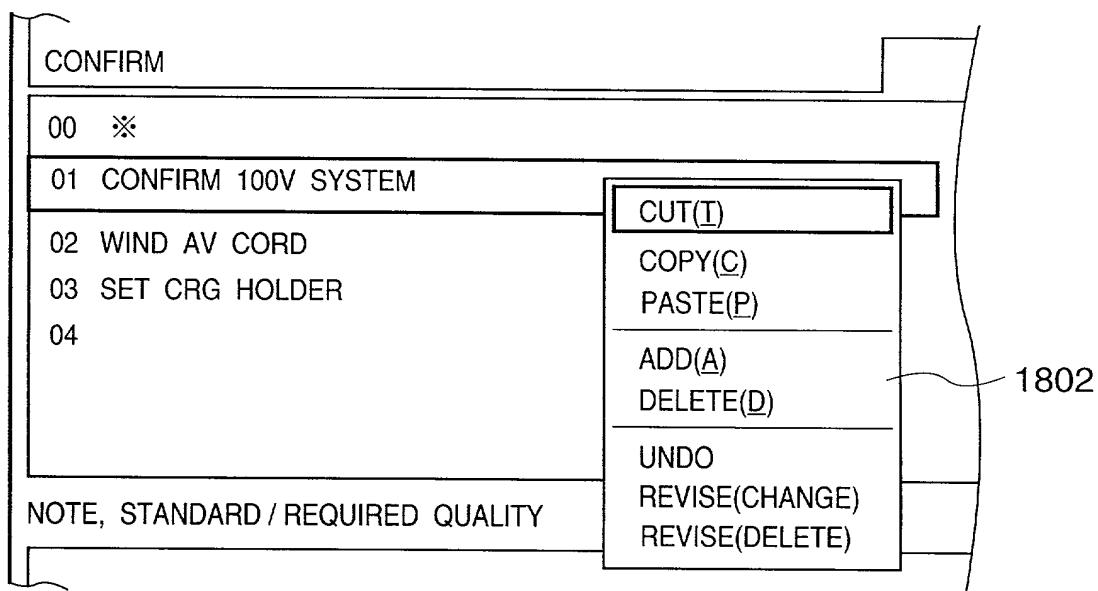
**F I G. 17**



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## FIG. 18

100 200 300 400 500 600



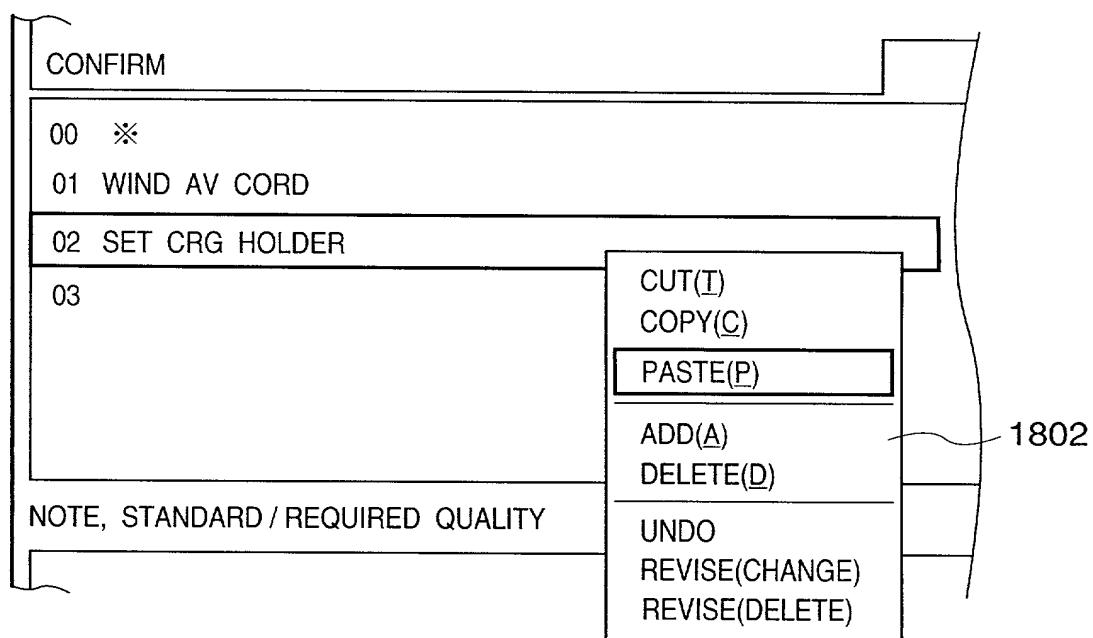
## FIG. 19

CONFIRM	～する
00 ※	
01 WIND AV CORD	
02 CONFIRM 100V SYSTEM	
03 SET CRG HOLDER	
04	

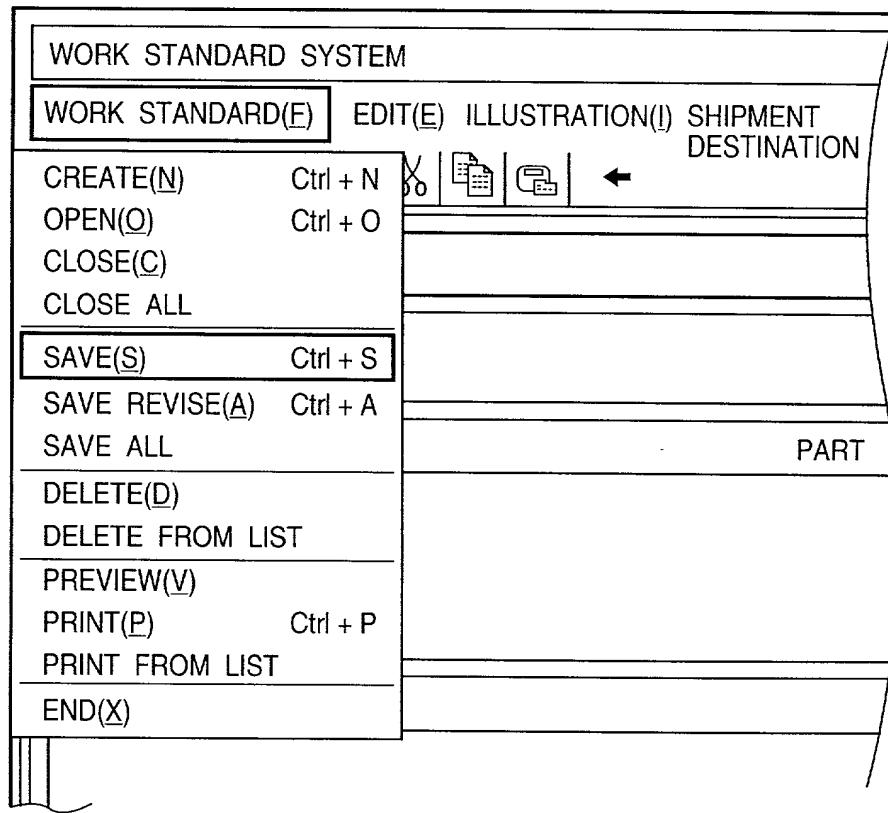
NOTE, STANDARD / REQUIRED QUALITY

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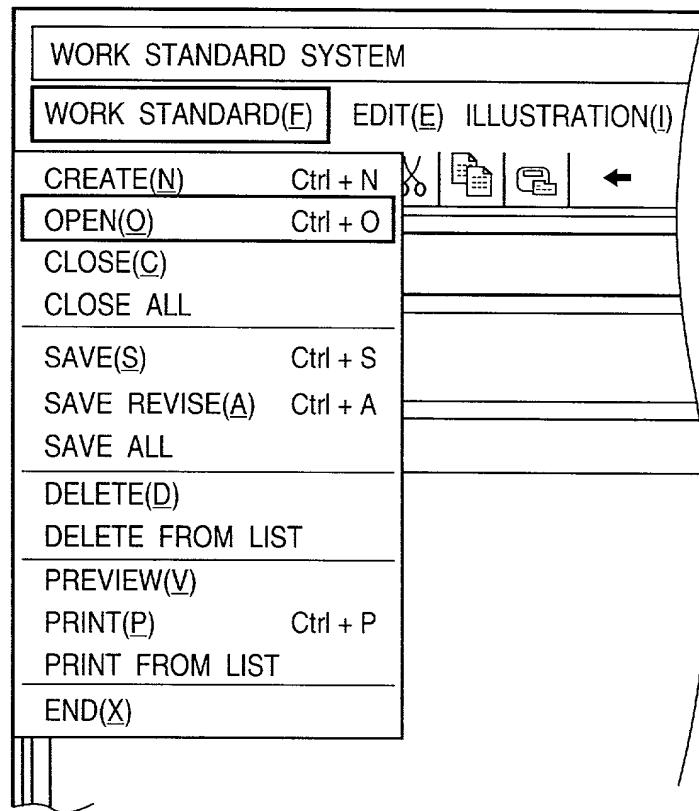
## FIG. 20



## FIG. 21



## FIG. 22



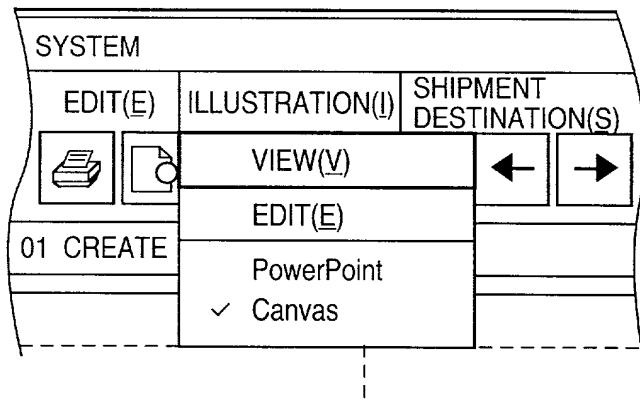
# FIG. 23

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WORK STANDARD SYSTEM			
<input checked="" type="radio"/> LATEST REVISION NUMBER <input type="radio"/> ALL			
MANAGEMENT NO.	REVISION NUMBER	WORK NAME	DATE OF REGISTRATION
SO - 04 - 01(4) - E	01	ASFu取付	1997/09/13
SO - 01 - 01(3) - E	01	ベース・トレーリ取付	1997/09/01
SO - 01 - 03 - E	01	ベース・トレーリ取付	1997/09/01
SO - 01 - 04 - E	01	ベース・トレーリ取付	1997/09/01
↓			
SO - 06 - 01 - E	01	線処理	1997/09/01
SO - 06 - 02 - E	01	線処理	1997/09/01
SO - 06 - 03 - E	01	線処理	1997/09/01
SO - 07 - 01(2) - E	01	レールグリス塗布	1997/09/01
SO - 08 - 01 - E	01	レール取付	1997/09/01
↓			
<input type="button" value="OK"/>		<input type="button" value="CANCEL"/>	

2301

## FIG. 24



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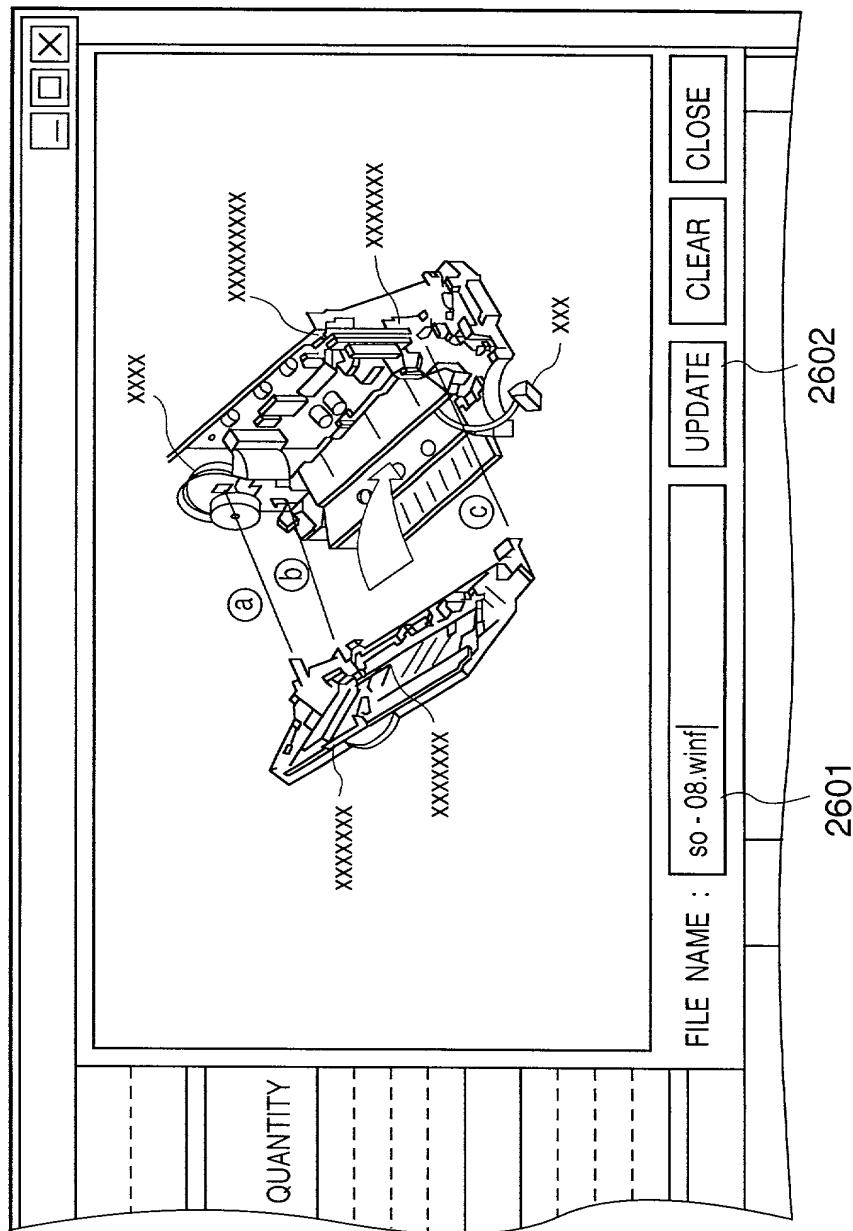
FIG. 25

302

2500

WORK STANDARD 01 CREATION					
<input type="checkbox"/> APPLIED					
PART NUMBER	PART NAME				
303					
TOOL / TREATMENT DEVICE					
WORK PROCEDURE					
FILE NAME : <input type="text"/>					
<input type="button"/> UPDATE <input type="button"/> CLEAR <input type="button"/> CLOSE					
REVISION NUMBER	CONTENTS OF REVISION	DATE	PERSON IN CHARGE	APPROVE	WORK NAME
01 CREATED		1997/09/25			
					MANAGEMENT NO.

# FIG. 26



## FIG. 27

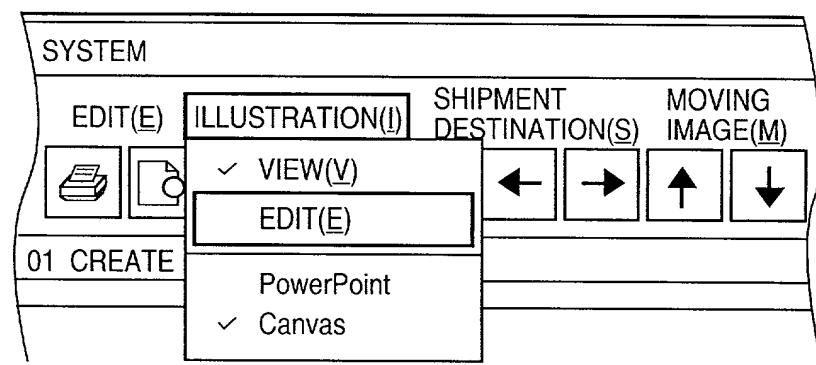
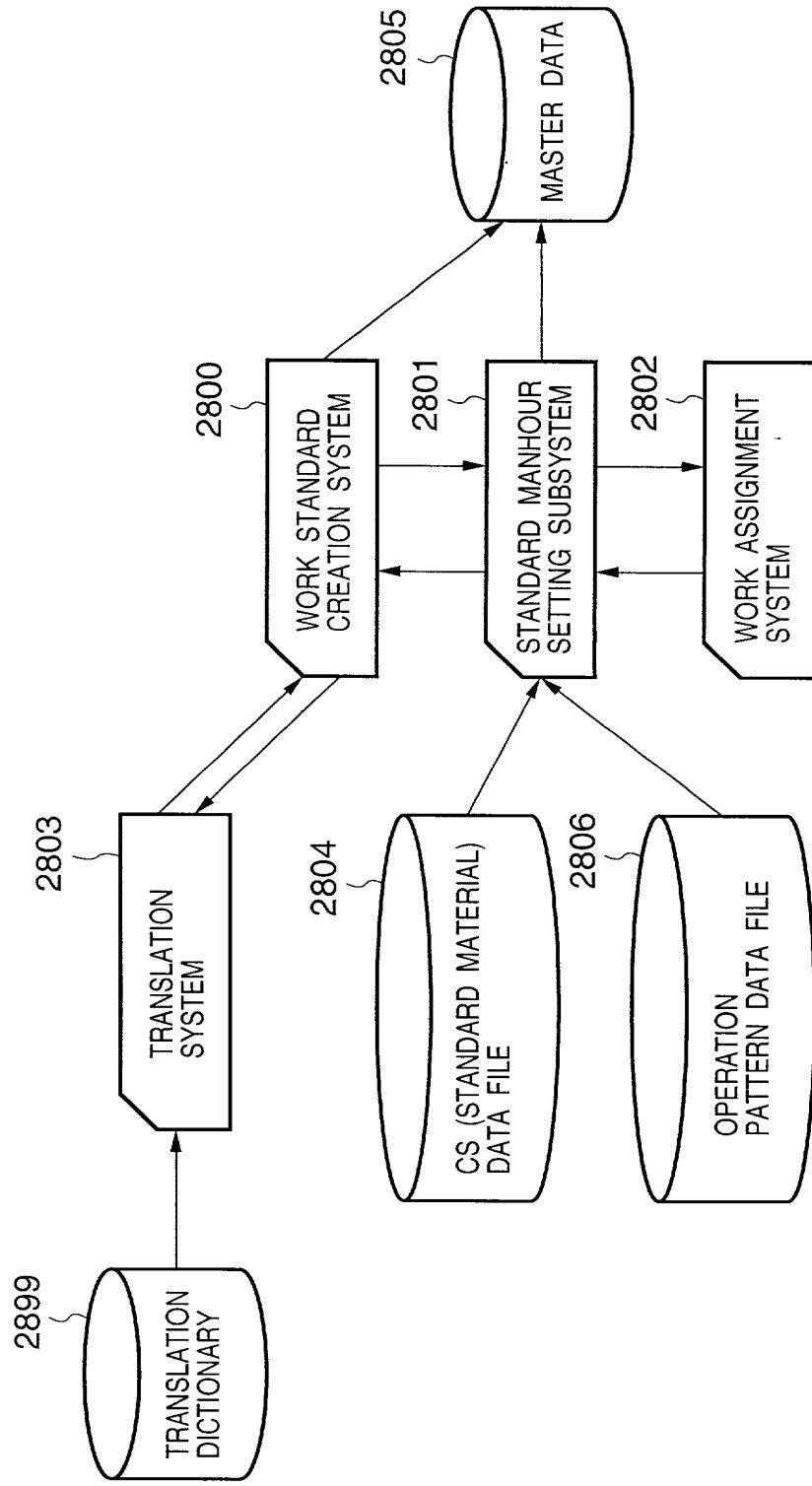
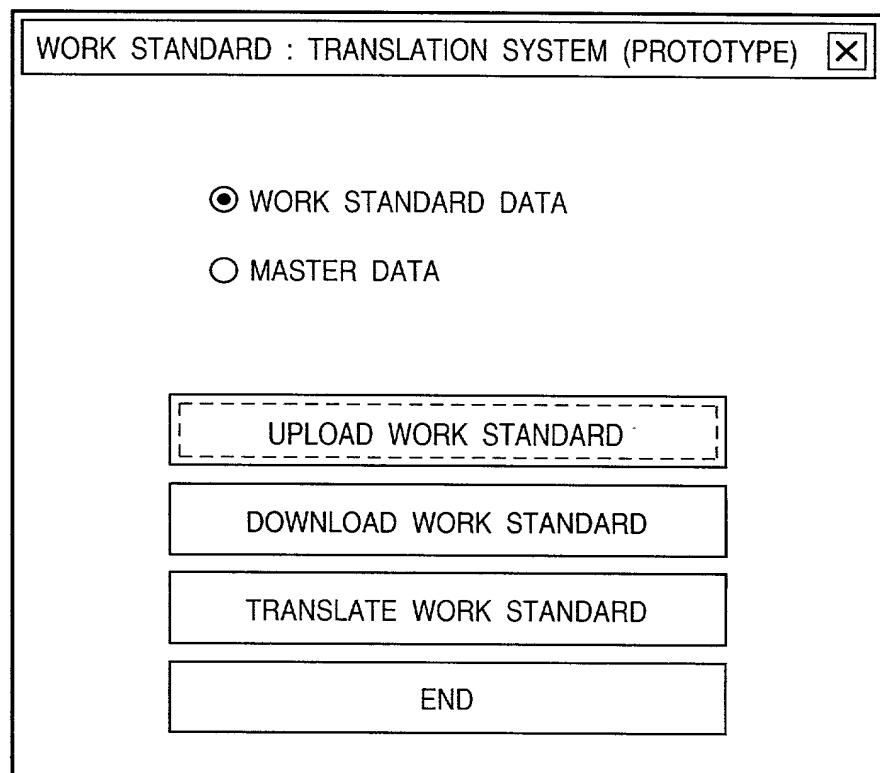


FIG. 28



## FIG. 29



# FIG. 30

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TRANSLATION OF WORK STANDARD		DISPLAY DATA		DISPLAY LANGUAGE	
REPRESENTATIVE MODEL NAME :	A252	<input type="radio"/>	ALL	<input type="radio"/>	JAPANESE
PREPUSES NAME :	PLATEN UNIT	<input type="radio"/>	UNTRANSLATED	<input checked="" type="radio"/>	ENGLISH
		<input type="radio"/>	TOTAL UNIT	<input type="radio"/>	UNCHECKED
		<input type="radio"/>	ASSEMBLY	<input checked="" type="radio"/>	ASSEMBLY
AUTOMATIC TRANSLATION CHECK					
MANAGEMENT NO.	REVISION NUMBER	WORK NAME			
PT - 010 - 010	01	クリーナu取付	X		
PT - 010 - 020	01	クリーナu取付	X		
PT - 010 - 030	01	クリーナu取付	X		
PT - 070 - 030	01	切換アームAssy組立	X		
PT - 080 - 010	01	伝達ローラu取付	X		
PT - 090 - 010	01	伝達ローラu取付	X		
PT - 100 - 010	01	紙押え取付	X		
SELECT ALL		<input type="button" value="CANCEL SELECT"/>	<input type="button" value="VIEW"/>	<input type="button" value="TRANSLATE"/>	<input type="button" value="CLOSE"/>
3006 3007 3008 3005					
3001 3002 3003 3004 3000					

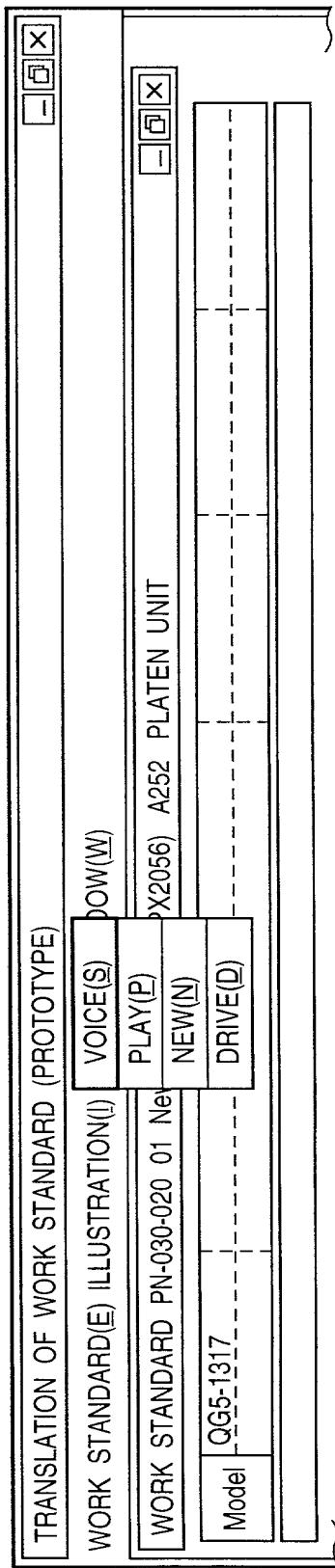
FIG. 31

# FIG. 32

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WORK PROCEDURE	<input type="checkbox"/>
VOICE(W)	
JAPANESE	
WORK PROCEDURE	
ブレードレバーバネをブレードレバーの①部に引っ掛ける	
3201	3200
01 ブレードレバーバネをブレードレバーの①部に引っ掛ける	
02 ブレードレバーを矢印②方向にスライドさせ引っ掛け無くバネ力で戻ることを確認する	
03 ブレードレバーバネ先端がブレードホルダー先端まで圧入されていることを確認する	
ENGLISH	
Procedure	
The blade lever spring hooks to ① of the blade lever.	
3203	3202
01 The blade lever spring hooks to ① of the blade lever.	
02 Side the blade lever in the direction of arrow ② and there is no catch and n....	
03 Check press-fitting the blade lever shaft leading edge to the braid folder leading ed....	
3204	3203
<input type="checkbox"/> TRANSLATE	<input type="checkbox"/> OK
<input type="checkbox"/> CANCEL	<input type="checkbox"/>

# FIG. 33



## FIG. 34

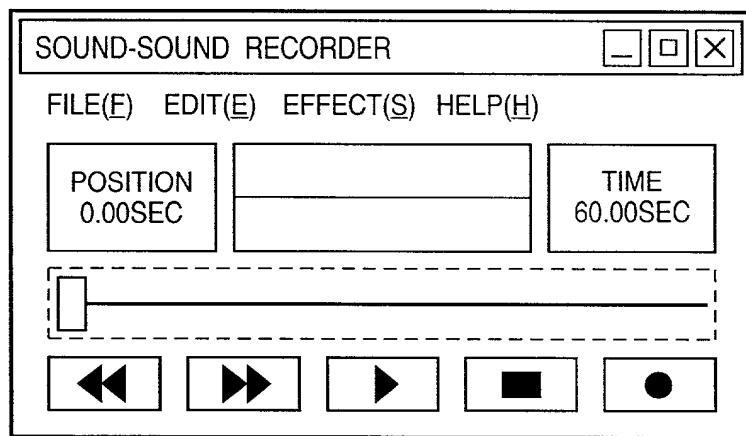


FIG. 35

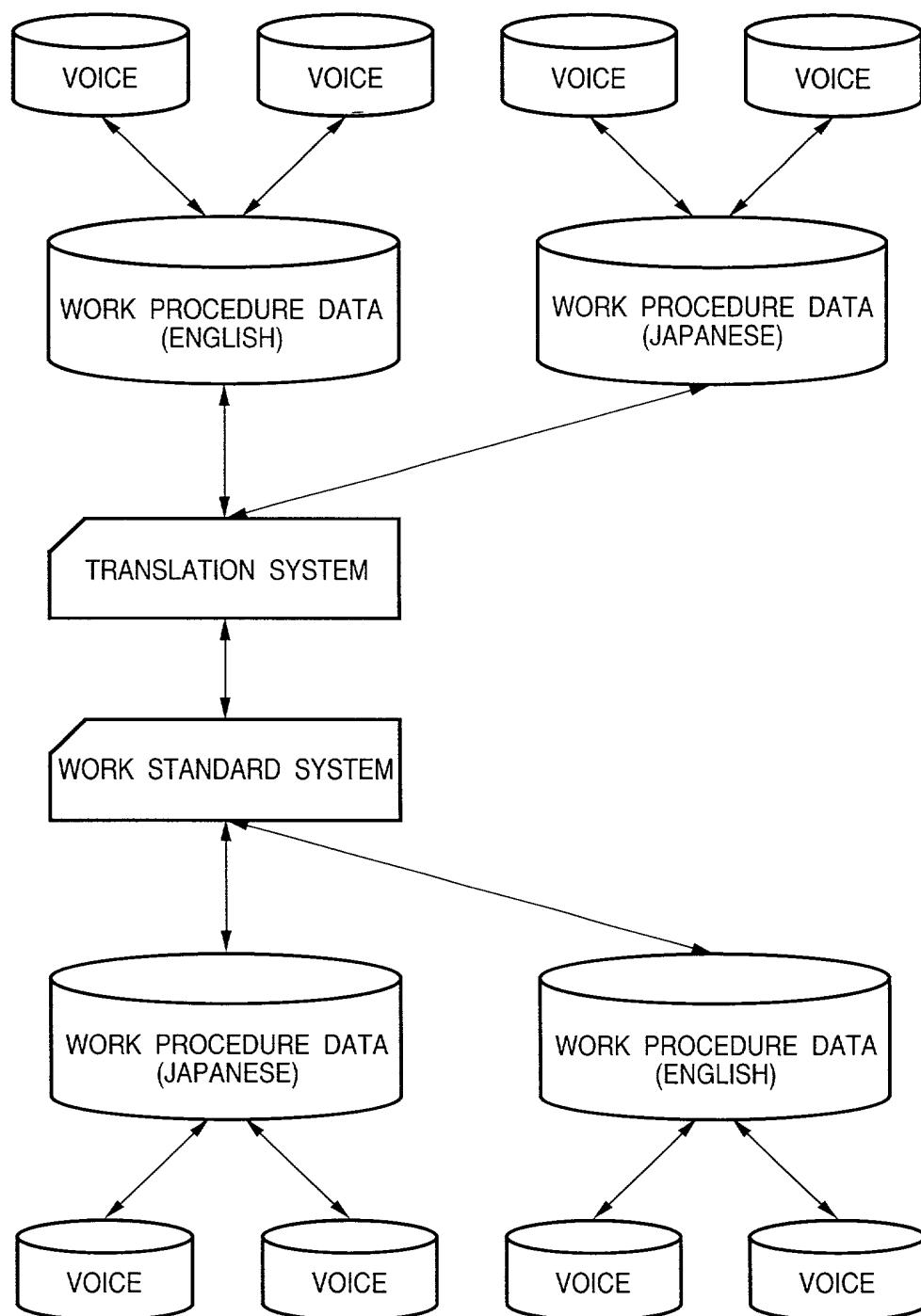


FIG. 36

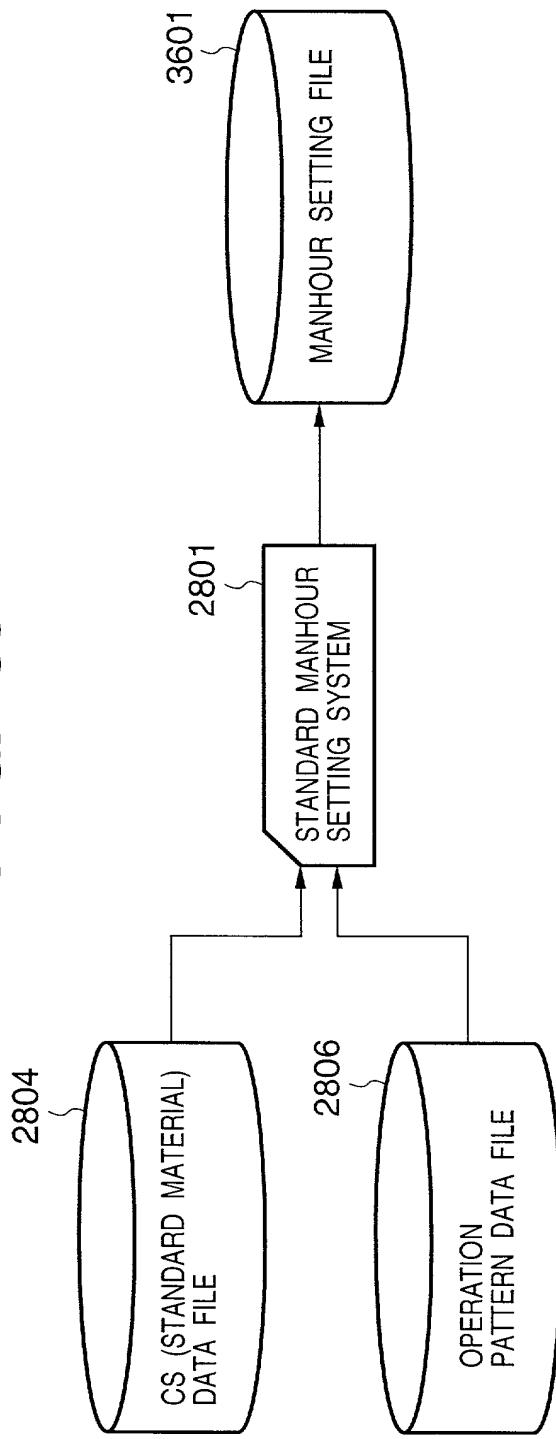


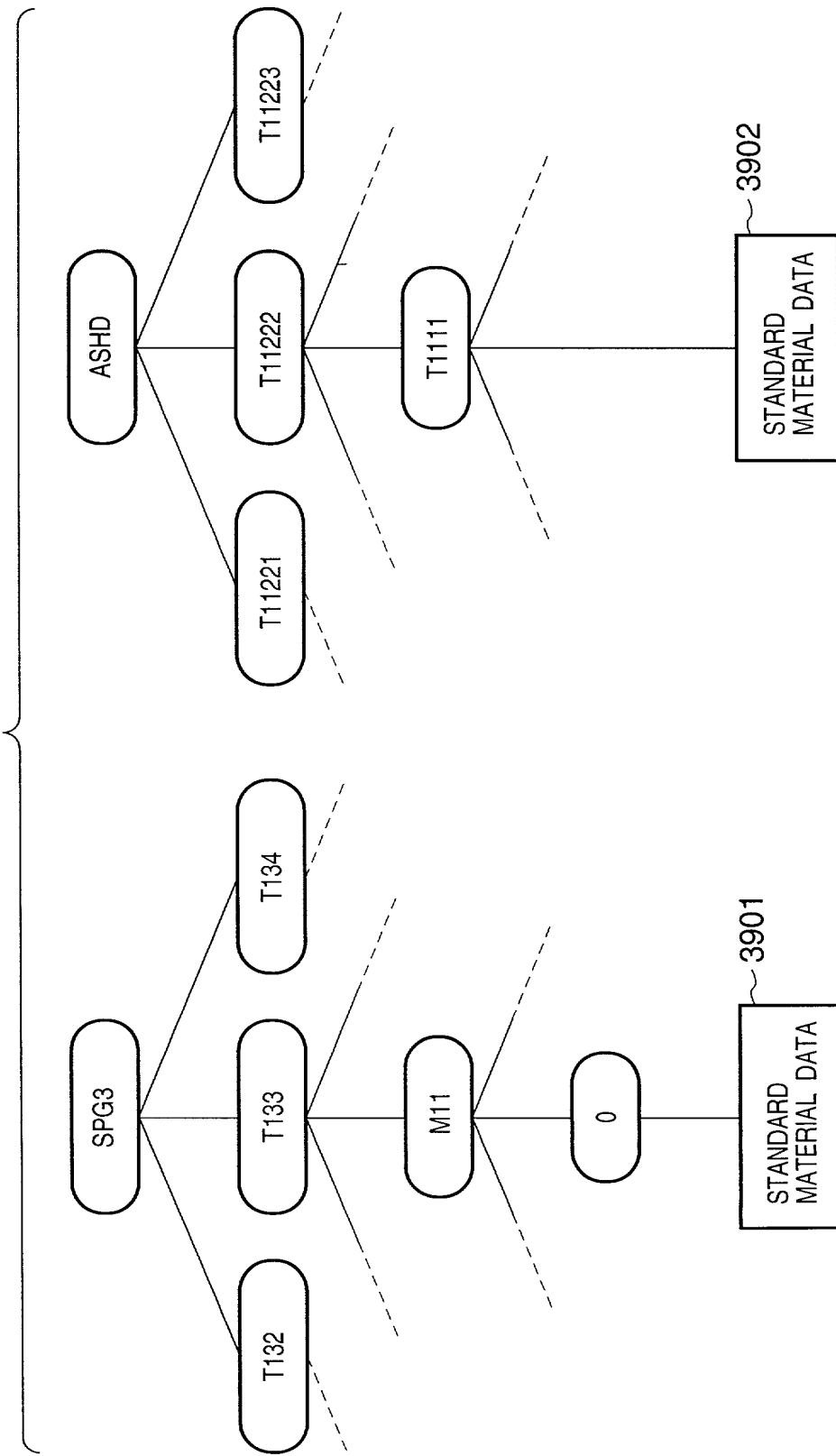
FIG. 37

# FIG. 38

## STANDARD MATERIAL DATA

COMMENT 1	OBJECT	COMMENT 2	VERB	SET CONDITION DATA

FIG. 39



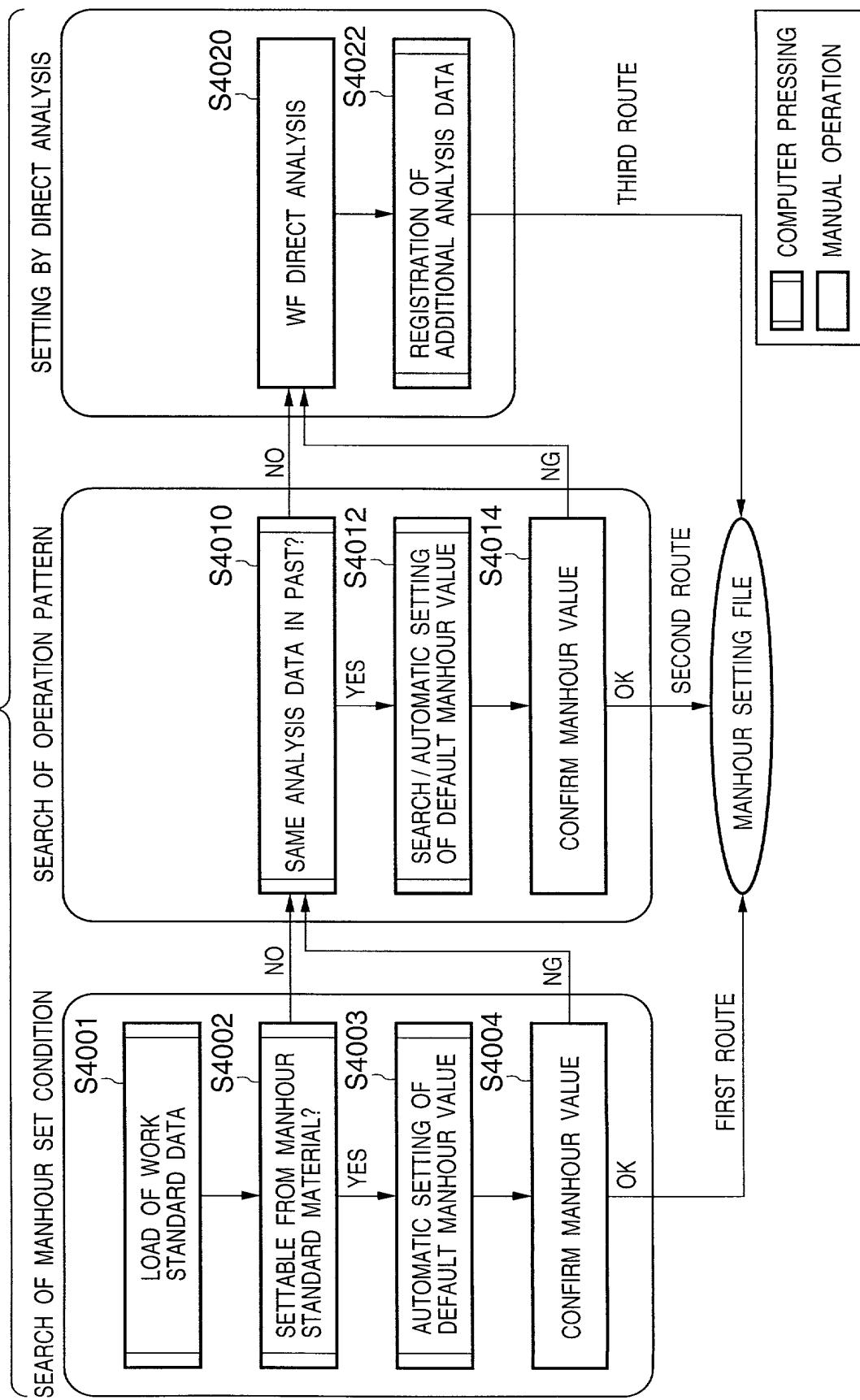
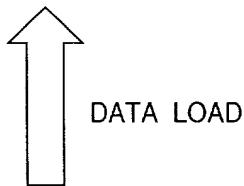


FIG. 40

FIG. 41

3601



● ELEMENT WORK NAME

No.	COMMENT 1	OBJECT	COMMENT 2	VERB
1		負荷バネを	負荷バネ取付治具に	組込む
2	治具の	SWを		ONする
3		分離ローラ軸を	負荷バネ取付治具に	組込む
4	治具の	SWを		OFFにする
5		分離ローラ軸を	治具より	外す

FIG. 42

3601

### MATCH

### SEARCH KEYWORD(KW)

No.	COMMENT 1	OBJECT	COMMENT 2	VERB	MANHOUR STANDARD MATERIAL	TIME VALUE
1	*	*バネを	*に	組込む	SPG3 T133 / M11 / 0	41RU
2	*	*を	*に	組込む	ASHED T11222 / T1111	37RU
3	*	*を	*より	外す	PUMQ T2111 / T111111	16RU
4	*	*Eリングを	*	組込む	RIN2 T11211 / SO	76RU
5	*	*コネクタを	*	差し込む	CONN T11211 / SO	41RU
6	*	*	*	増し締めする	SCR6 M211 / 1	23RU

FIG. 43

3601

## MATCH

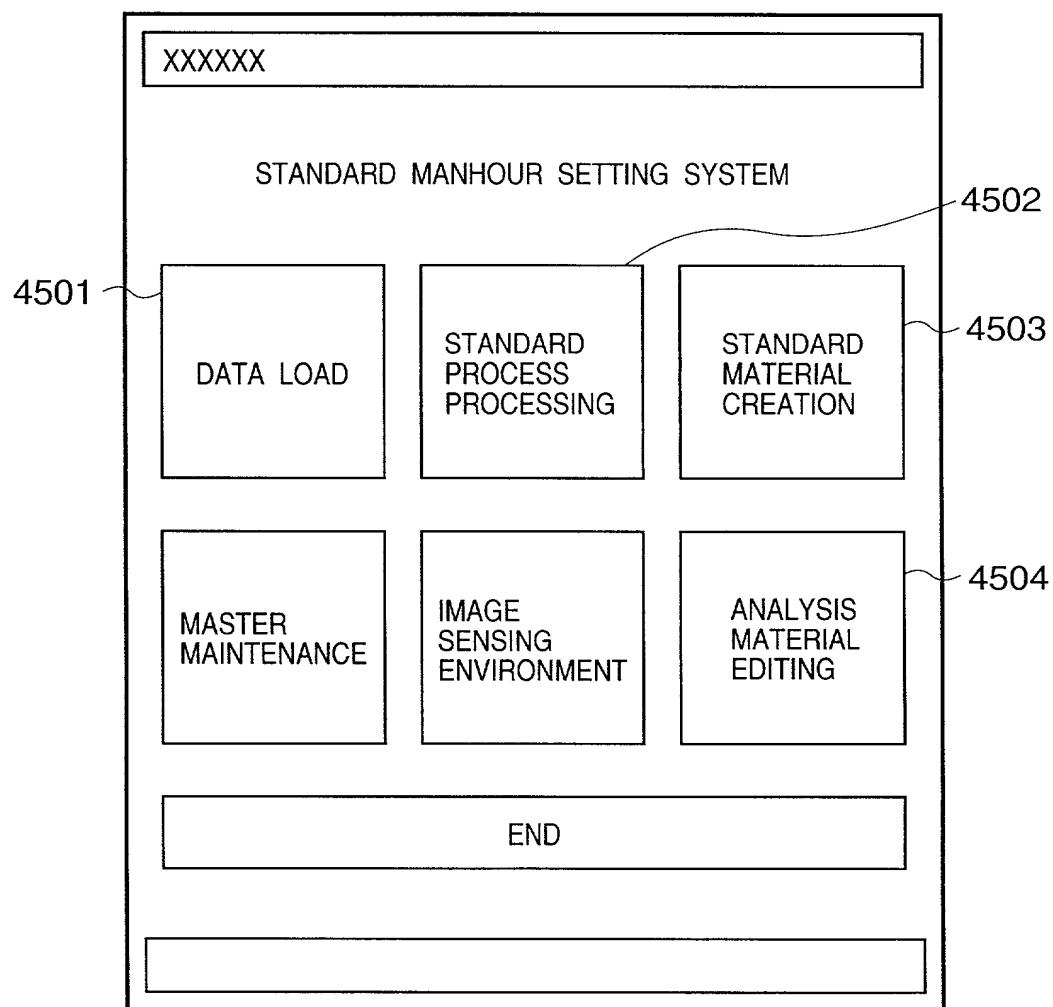
No.	COMMENT 1	OBJECT	COMMENT 2	VERB	VERB PATTERN	TIME VALUE
1	治具の	SWを		ONする	/GET:-50E/M:-10E	8RU
2	治具の	SWを		OFFする	/GET:-50E/M:-10E	8RU
3		読取操作部uを		閉める	/GET:-50E/M:-50E	10RU
4		CRGトアを		閉める	/GET:-50E/M:-50E	10RU
5		読取操作部uを		閉める	/GET:-50E/M:-50E	10RU
6		電源コードを		抜く	/GET:-50EGr2/M:-10E	16RU
7		測定用電源コードを		抜く	/GET:-50EGr2/M:-10E	16RU

FIG. 44

3601

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## FIG. 45



# FIG. 46

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PRODUCT NUMBER	WORK STANDARD	PRODUCT SYMBOL	NAME	PREVIOUS LOAD DATE
XXXXXX	XXXX	XX	XXXX	XXX
0 - CLOCK	BL - OLD	SET IN 1996		
XXXXXX				
xyz - test				
test - 01				
test - AMI				

4601

4602 4603 4604 4605 4611

4609 4610 4612

4611

PRODUCT NUMBER :

NAME :

NAME :

OK

SELECT

CANCEL

**FIG. 47**

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S	PROVISIONAL MANAGEMENT NO.	PRODUCTION MANAGEMENT NO.	TOTAL	WORK NAME	COMPONENT SYMBOL	PREVIOUS LOAD DATE	LOADER
4705a	4705b	4706	4707	4708	4701	4702	4703
SET MANHOUR>							

XXXXXX

FILE(E) EDIT(E) EXECUTE(S) VIEW(V)

BJC - 4200 → BJC - 970909

4704

## FIG. 48

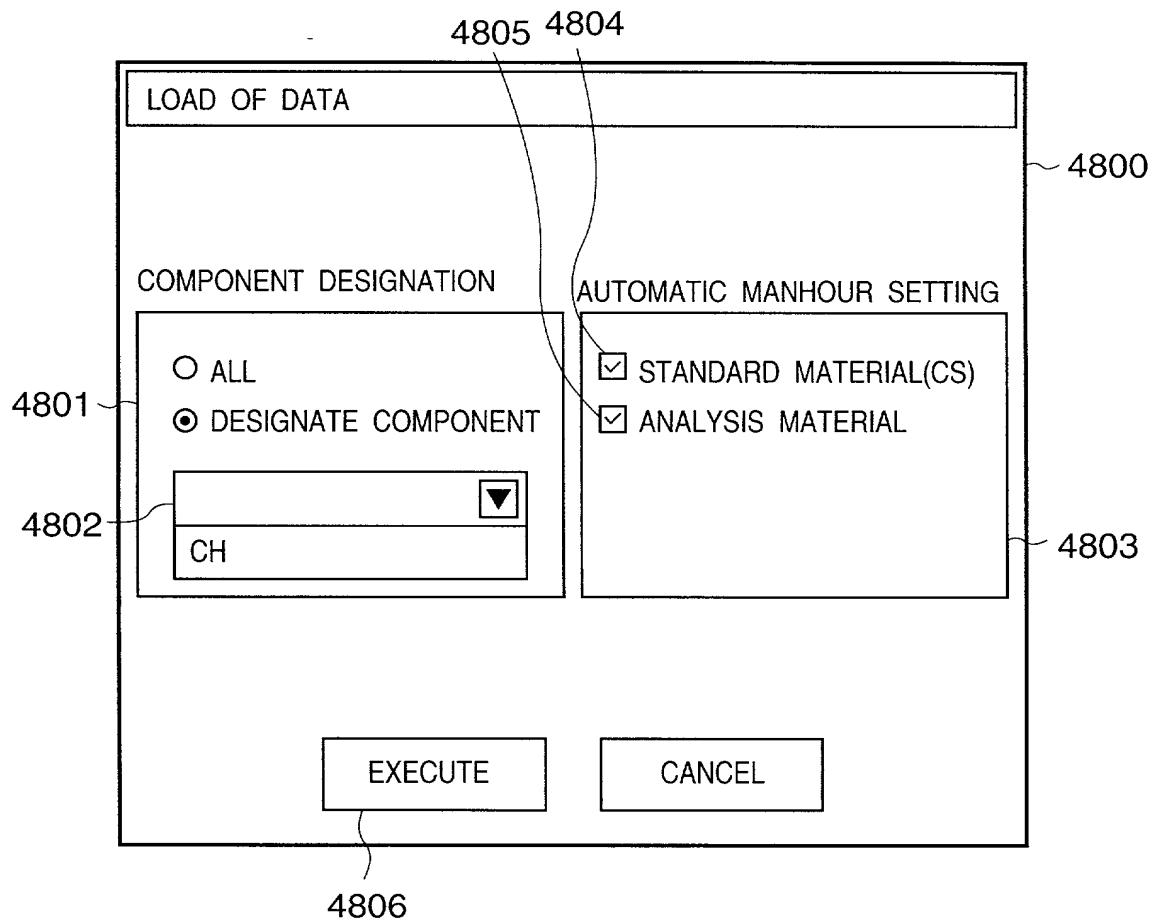


FIG. 49

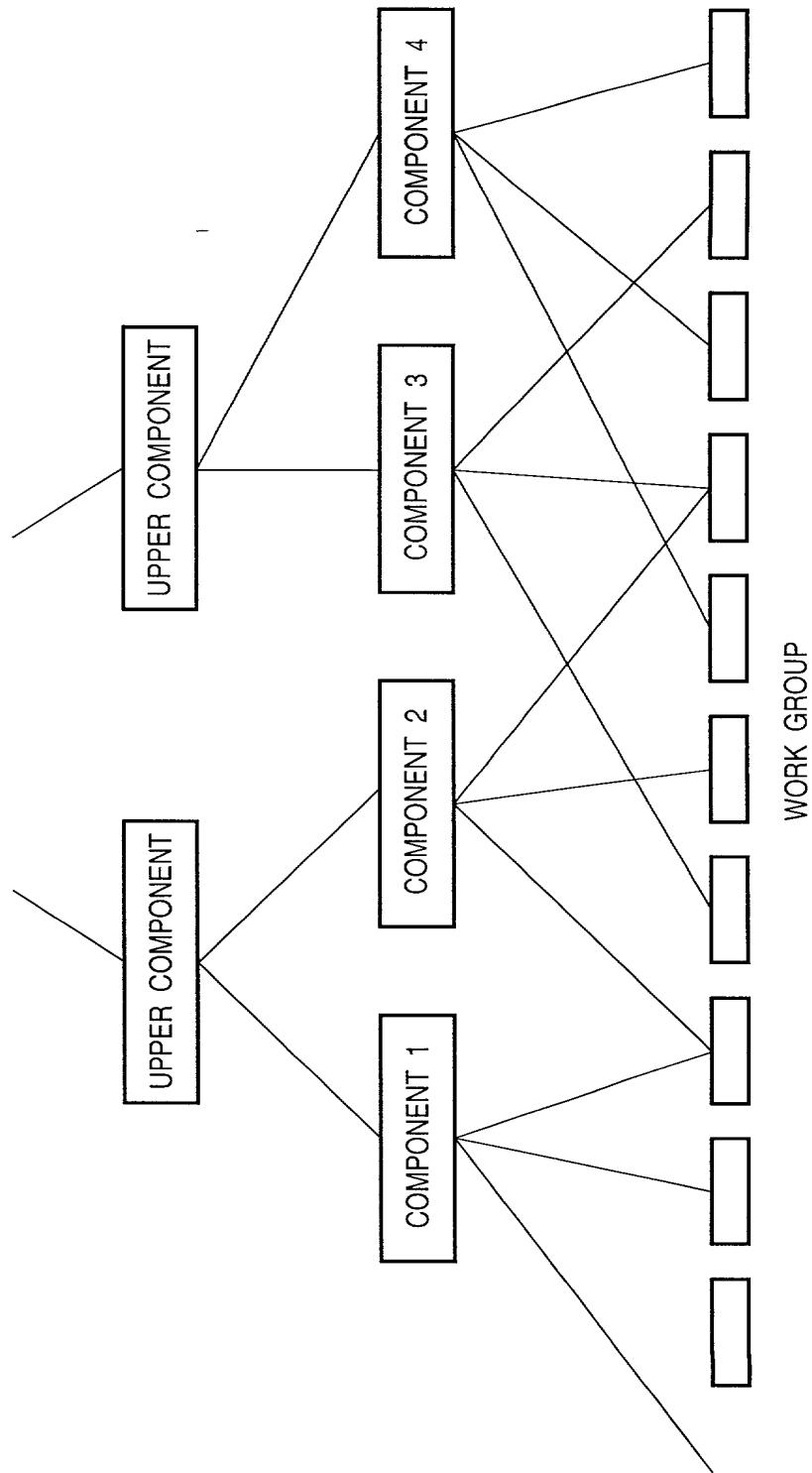
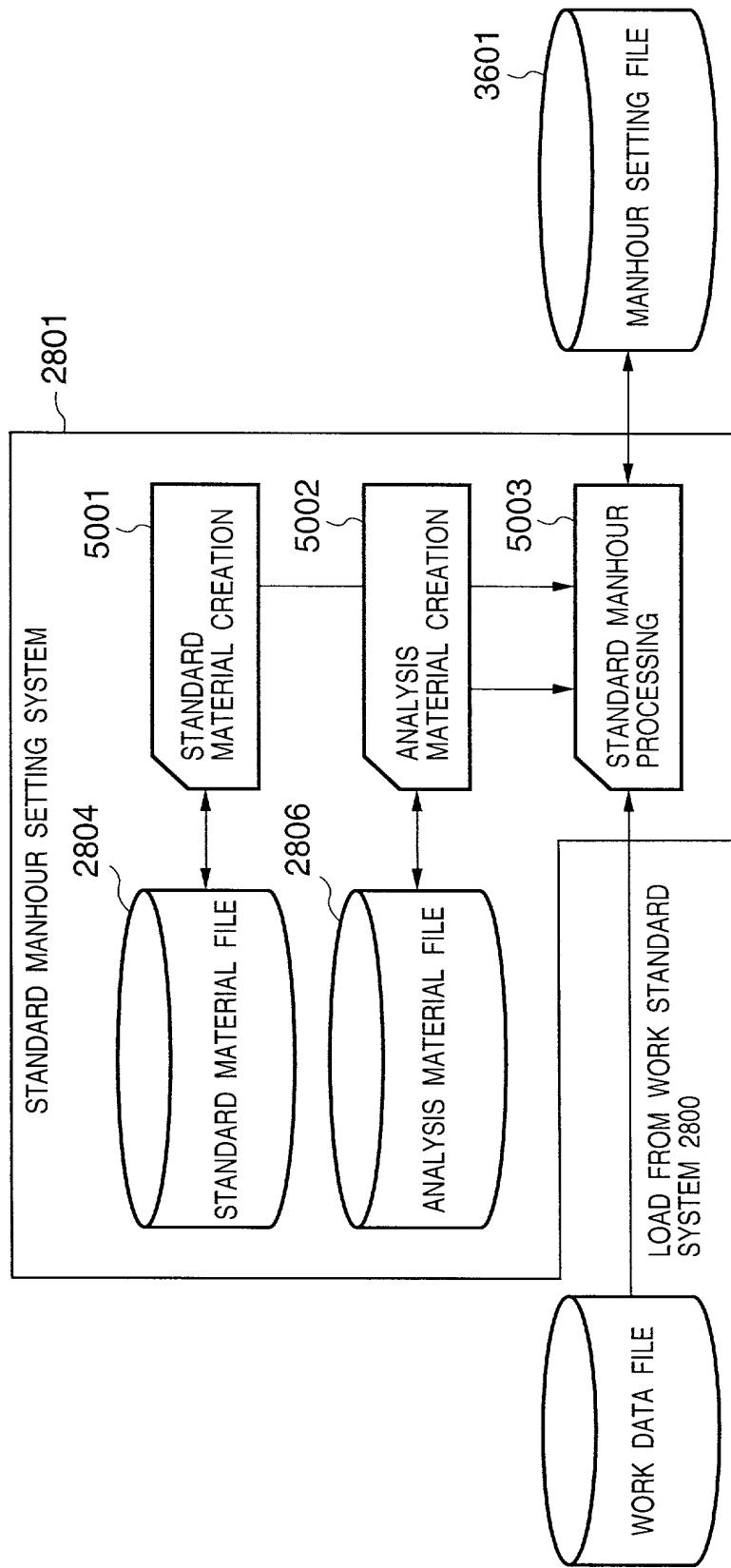


FIG. 50



## FIG. 51

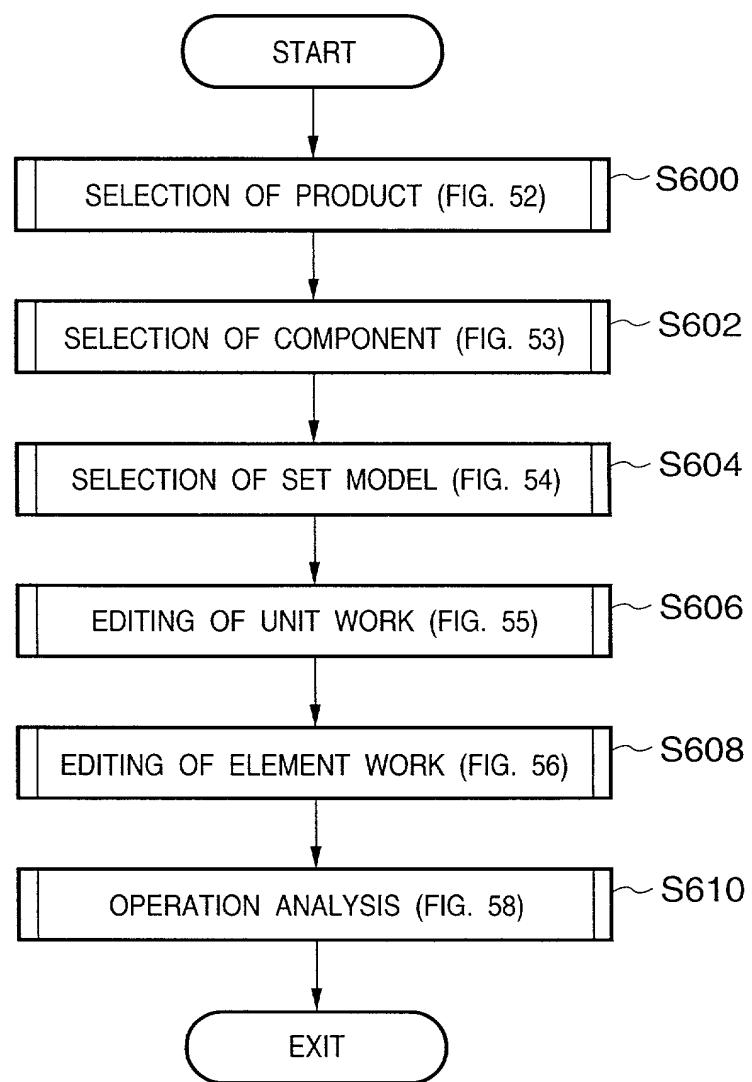


FIG. 52

SELECTION OF PRODUCT																						
FILE(F)	EDIT(E)																					
<input type="checkbox"/> 	<input type="checkbox"/> 																					
<input type="checkbox"/> 	<input type="checkbox"/> 																					
<input type="checkbox"/> 	<input type="checkbox"/> 																					
<input type="checkbox"/> 	<input type="checkbox"/> 																					
<table border="1"> <thead> <tr> <th>PRODUCT SYMBOL</th> <th>NAME</th> <th>PREVIOUS UPDATE DATE</th> </tr> </thead> <tbody> <tr> <td>BJ - 970909</td> <td>XXXXX</td> <td>1997/09/22 10:17:30</td> </tr> <tr> <td>BJ - STAND</td> <td>TEST 01 Standard</td> <td>1997/09/12 15:09:09</td> </tr> <tr> <td>BJ - test</td> <td>250 TESTS</td> <td>1997/09/18 10:38:14</td> </tr> <tr> <td>BJ250</td> <td>STAND PRODUCT</td> <td>1997/09/17 17:58:59</td> </tr> <tr> <td>ST01</td> <td></td> <td>1997/09/12 16:02:34</td> </tr> <tr> <td>STAND01</td> <td></td> <td>1997/09/19 15:46:04</td> </tr> </tbody> </table>		PRODUCT SYMBOL	NAME	PREVIOUS UPDATE DATE	BJ - 970909	XXXXX	1997/09/22 10:17:30	BJ - STAND	TEST 01 Standard	1997/09/12 15:09:09	BJ - test	250 TESTS	1997/09/18 10:38:14	BJ250	STAND PRODUCT	1997/09/17 17:58:59	ST01		1997/09/12 16:02:34	STAND01		1997/09/19 15:46:04
PRODUCT SYMBOL	NAME	PREVIOUS UPDATE DATE																				
BJ - 970909	XXXXX	1997/09/22 10:17:30																				
BJ - STAND	TEST 01 Standard	1997/09/12 15:09:09																				
BJ - test	250 TESTS	1997/09/18 10:38:14																				
BJ250	STAND PRODUCT	1997/09/17 17:58:59																				
ST01		1997/09/12 16:02:34																				
STAND01		1997/09/19 15:46:04																				
<input type="checkbox"/> SET MANHOUR <input type="checkbox"/> EXTRACT DATA <input type="checkbox"/> CREATE HOST TRANSFER <input type="checkbox"/> ANALYZE DATA <input type="checkbox"/> END																						

FIG. 53

SELECTION OF COMPONENT	
FILE(F)	EDIT(E)
<input type="checkbox"/>	
<input type="checkbox"/>	
<input type="checkbox"/>	<input type="checkbox"/>
PRODUCT SYMBOL : BJ - 4200	
NAME : BJ - 4200	
COMPONENT SYMBOL	NAME
► BK	XXXX
CH	CHECK PROCESS
KO	PACKAGE
PREVIOUS UPDATE DATE	
1997/09/22 11:09:59	
1997/09/12 11:09:59	
1997/09/18 11:21:07	
NEXT <input type="checkbox"/> DOWNLOAD <input type="checkbox"/> UPLOAD <input type="checkbox"/> BACK UP <input type="checkbox"/> LIST <input type="checkbox"/> CANCEL ACCESS FLAG <input type="checkbox"/> END	

FIG. 54

SELECTION OF MODEL			
FILE(E)	EDIT(E)	VIEW(V)	<input type="checkbox"/> <input type="checkbox"/> <input checked="" type="checkbox"/> <input type="checkbox"/>
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/> <input type="checkbox"/> <input checked="" type="checkbox"/> <input type="checkbox"/>
PRODUCT NUMBER : BJ - 970909		NAME : 97 - 09 - 09 LOAD	
COMPONENT SYMBOL : CH		NAME :	
SET	MODEL	SYMBOL	QUANTITY
►	A250	IQ	
	BJC	- 4200LX	
	BJC	- 4200 SYSTEM	
	BJC	- 420J	
	BJC	- 420J(BLACK)	
	BJC	- 4300	
	BJC	- 430J	
		XXXX	
			1997/09/09 10:46:33

FIG. 55

SELECTION OF MODEL							
FILE(E) EDIT(E) VIEW(V)							
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
PRODUCT SYMBOL : BJ - 970909		NAME : 097 - 09 - 09		LOAD	SET MODEL SYMBOL : BJC - 4300	LATEST REVISION NUMBER	
COMPONENT SYMBOL : ON		NAME : NAME : x x x x x x x		UPDATE DISPLAY			
S	FORMAL MANAGEMENT NO.	REVISION	UNIT WORK NAME	MANHOUR	USE	CS	FREQUENCY
▶ N 3	CH-01-01	1	電気チエック	0	0	0	0
N 4	CH-01-02(1)	1	電気チエック	0	0	0	0
N 5	CH-01-02(2)	1	電気チエック	0	0	0	0
N 6	CH-01-03	1	電気チエック	0	0	0	0
N 7	CH-01-04	1	電気チエック	0	0	0	0
N 23	CH-07-02(1)	1	フロントカバー取り付	0	0	0	0
N 24	CH-07-02(2)	1	フロントカバー取り付	0	0	0	0
N 25	CH-07-01(3)	1	フロントカバー取り付	0	0	0	0
N 26	CH-07-01(4)	1	フロントカバー取り付	0	0	0	0
No. FORMAL MANAGEMENT NO.		UNIT WORK NAME		MANHOUR	USE	FREQUENCY	
3	CH-01-01	ELECTRICAL CHECK		0	0	1	2 3 4 5
				OK		○ CHANGE ○ INSERT ○ ADD	
5501	5507	5506		5502	5503	5504	5505

FIG. 56

XXXXXX	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
FORMAL MANAGEMENT NO. PU-03-01	UNIT WORK NAME : MOTOR ATTACHMENT		TOTAL MANHOUR : 0	<input type="checkbox"/>	NEXT UNIT WORK		
NO.	ELEMENT WORK NAME	REVISION	MANHOUR	USE	CS	SET CONDITION	
► 1	LFモータのケーブルと反対側の軸にターブルギア	1	0	0			
*							
COMMENT 1 : LFTモータのケーブルと反対側の軸に							
OBJECT : ターブルギアを							
COMMENT 2 : ギア溝の小さい方から							
VERB : 取付ける							
5604 5605 5603 5602 5601							

# FIG. 57

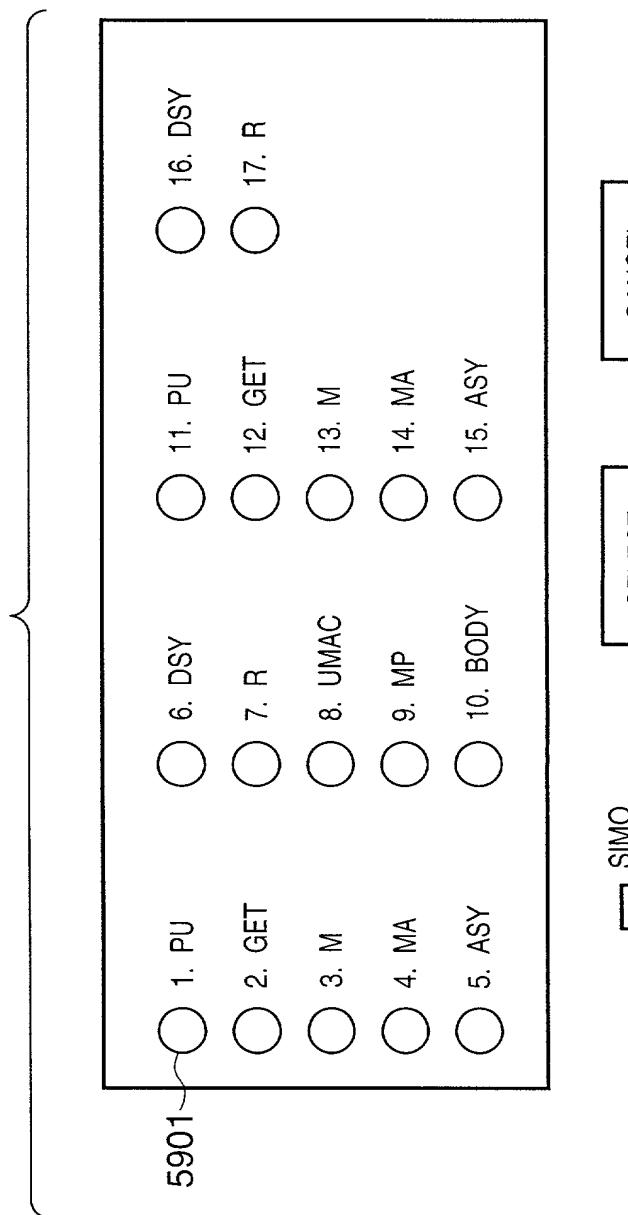
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EDITING OF ANALYSIS MATERIAL									
FILE(E) EDIT(E) VIEW(V)									
PRODUCT GENRE : <input type="text"/> <input type="button" value="▼"/>									
TYPE	COMMENT 1	OBJECT	COMMENT 2	VERB	ANALYSIS SYMBOL	MANHOUR USE	FREQUENCY COUNT	SET	DATE
▶	IP-キャラツフ：	本体を	矢印1の様に	入れる	-50/G11/N>6/-3	15	0 1 1	0	97/09/09 9:52
	IP-キャラツフ：	本体を	矢印1の様に	入れる	-50/E02/N>6	11	0 1 1	0	97/09/09 9:53
	IP-キャラツフ：	本体を	矢印1の様に	入れる	-50/G11/N>6/-3	15	0 1 1	0	97/09/09 9:55
	要素作業01		動詞		-50/G11/N>6/-3	15	0 1 1	0	97/09/10 16:34
	IP-キャラツフ：	本体を	矢印1の様に	入れる	-50/G11/N>6/-3	15	0 1 1	0	97/09/10 19:09
	キャラツフロツク		塗布する	Time100/Rate100	100	100	1 1 1	1	97/09/10 19:16
モード組立る：	フリタショーツ		入れ、セットする	M211/1/10	50	1 1 1	1 1	1	97/09/11 17:00
	フリタショーツ		裏面にする	T1221/M2311/0/0	12	0 1 1	0 1 0	0	97/09/11 17:34
1			1	T2221/M1211/0/1	24	0 1 1	0 1 0	0	97/09/11 17:20
2			2	T1221/M2311/0/0	12	0 1 1	0 1 0	0	97/09/11 17:24
フリタショーツ	PRカット	取付る	セットする		15	0 1 1	0 1 0	0	97/09/12 11:24
dgdfafdas		fdasfdasfasfad	*		16	0 1 1	0 1 0	0	97/09/12 12:10
dsdsffsdfsaf		fdasfdasfasfad	T21121/M1111/0/1	13	0 1 1	0 1 0	0	0	97/09/12 12:10
dgdfafdas		fdasfdasfasfad	*		16	0 1 1	0 1 0	0	97/09/12 13:39
フリタショーツ	PRカット	取付る	セットする		15	0 1 1	0 1 0	0	97/09/12 14:00
フリタショーツ	PRカット	取付る	セットする		16	0 1 1	0 1 0	0	97/09/12 14:00
フリタショーツ		セットする		Time100/Rate100	100	100	1 1 1	0	97/09/12 14:04

FIG. 58

OPERATION ANALYSIS		TOTAL SIMO POSITION		TOTAL MANHOUR VALUE:		NEXT ELEMENT WORK	
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
1 SET MAIN BODY TO PREDETERMINED POSITION		TOTAL SIMO VALUE: 0		TOTAL MANHOUR VALUE: 15		SIMO	
NO.	CONTENTS OF OPERATION	WF/OS	SET CONDITION	MANHOUR	USE	REMARKS	
► 1	XXXXXX	PU	-60/Gr1/N>6/-3	15	0		
*							

## FIG. 59



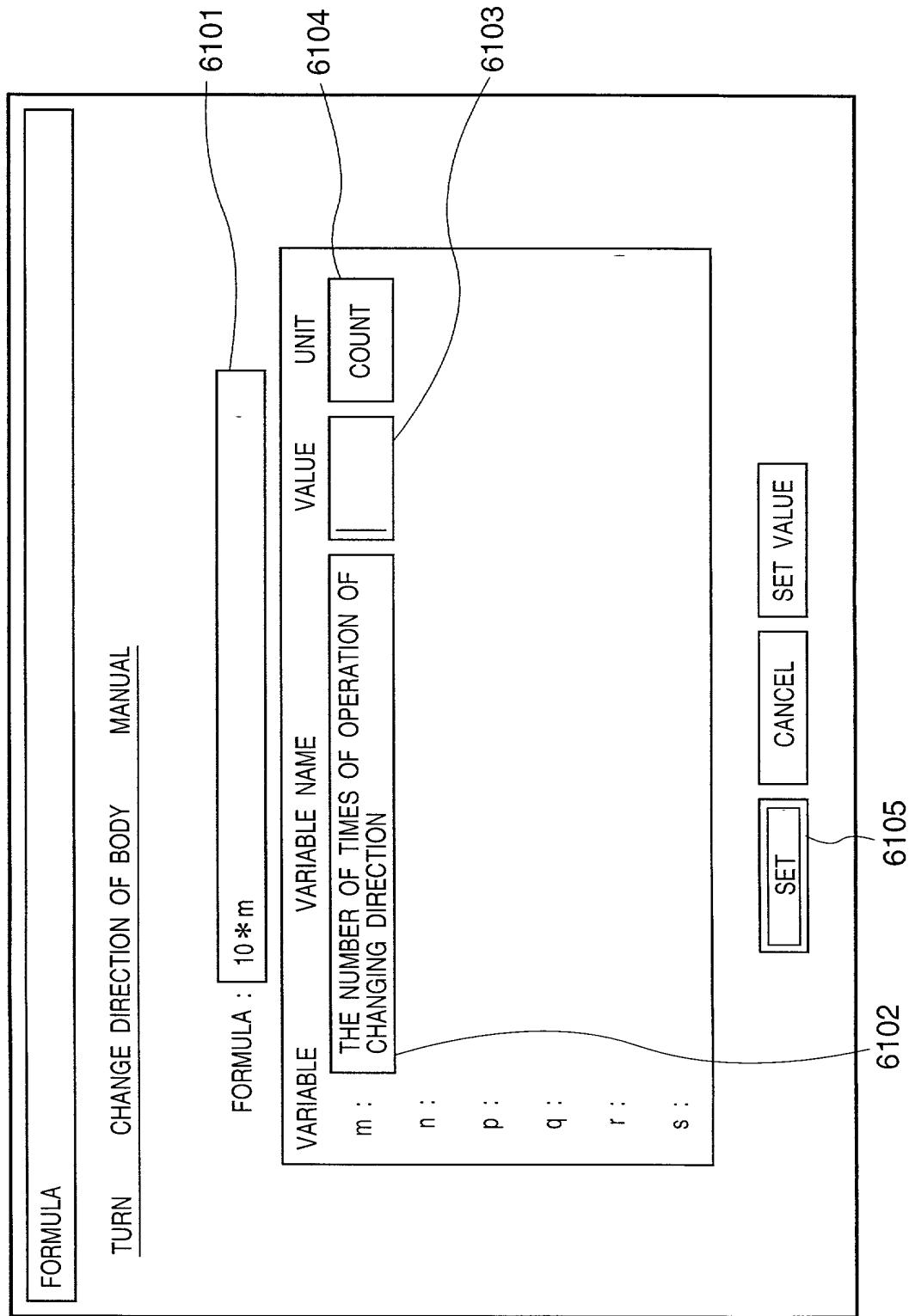
SIMO       SELECT       CANCEL

5902

FIG. 60

PU	PICK UP	MANUAL					
1 :	MOVING DISTANCE	1 -10cm	2 +10cm	3 >50cm	4	5	6
2 :	GRIP TYPE	Qr-3	Qr-2				
3 :	PRE-POSITIONING	NO	YES				
4 :	MAIN SIZE	-10mm	-6mm				
5 :	WEIGHT	<3Kg	>3Kg				
6 :							
				SET	CANCEL	SET VALUE	FORMULA
				6001      6002      6003			

FIG. 61



## FIG. 62

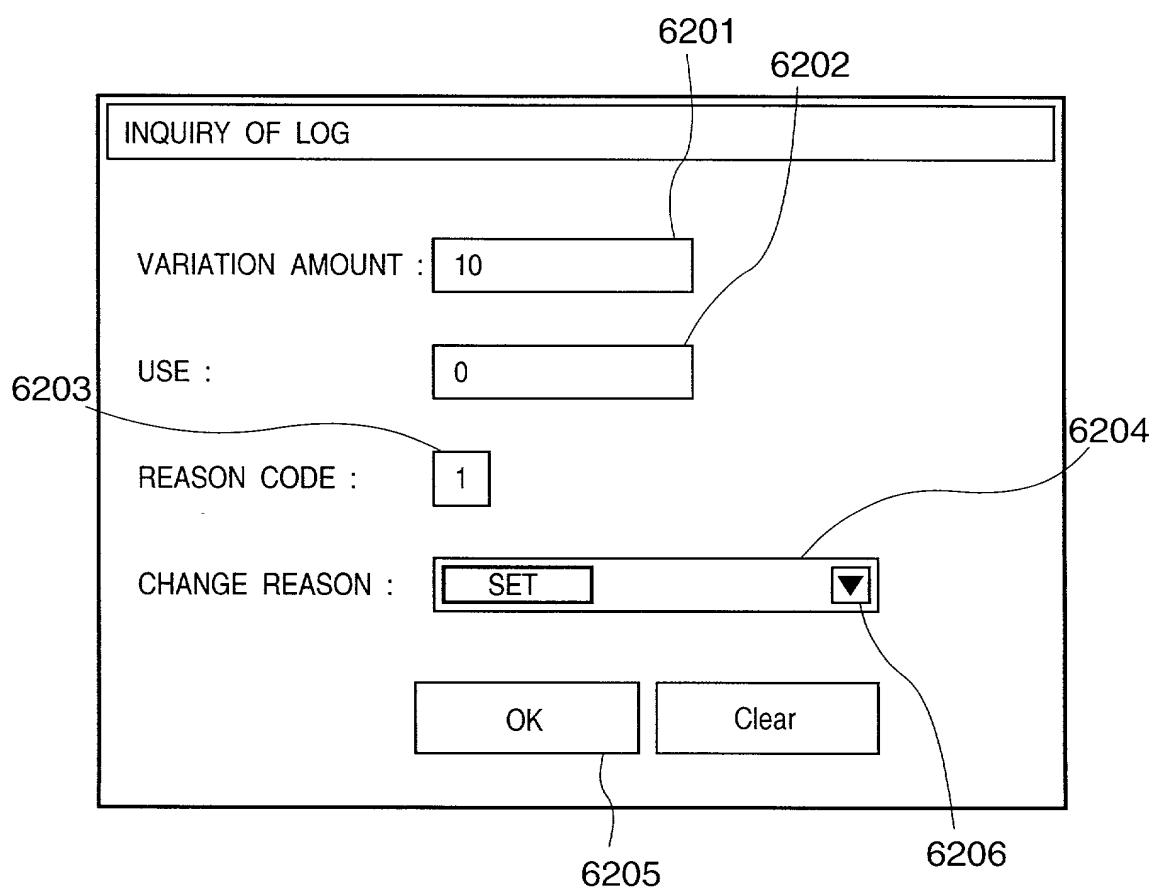


FIG. 63

FIG. 64

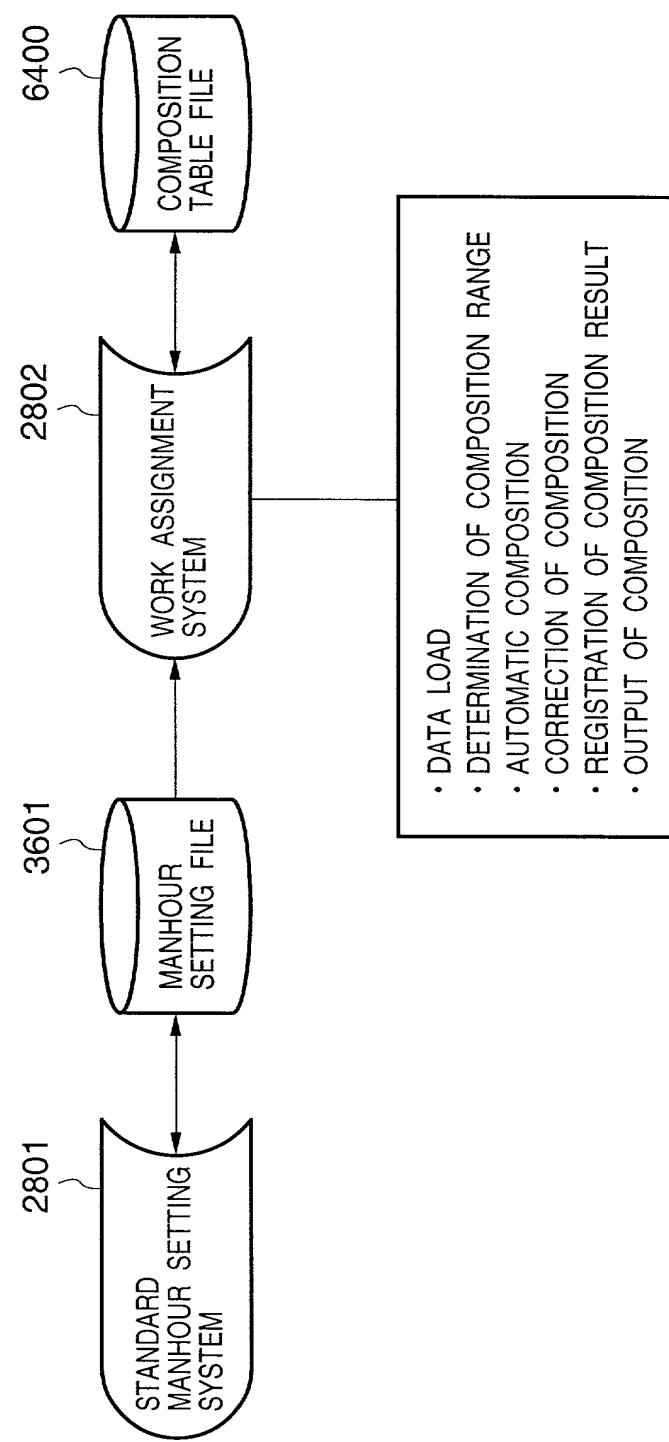


FIG. 65

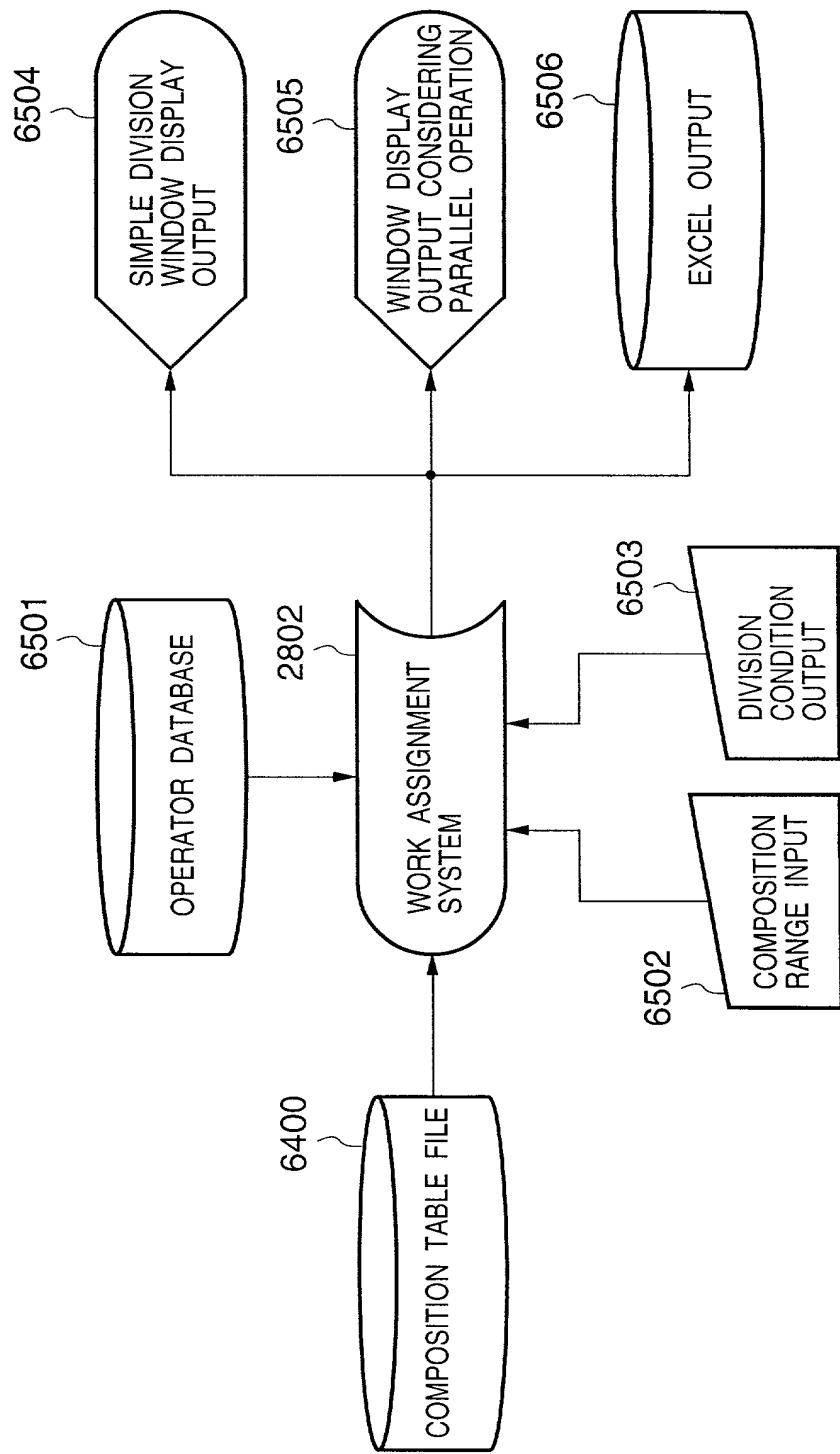
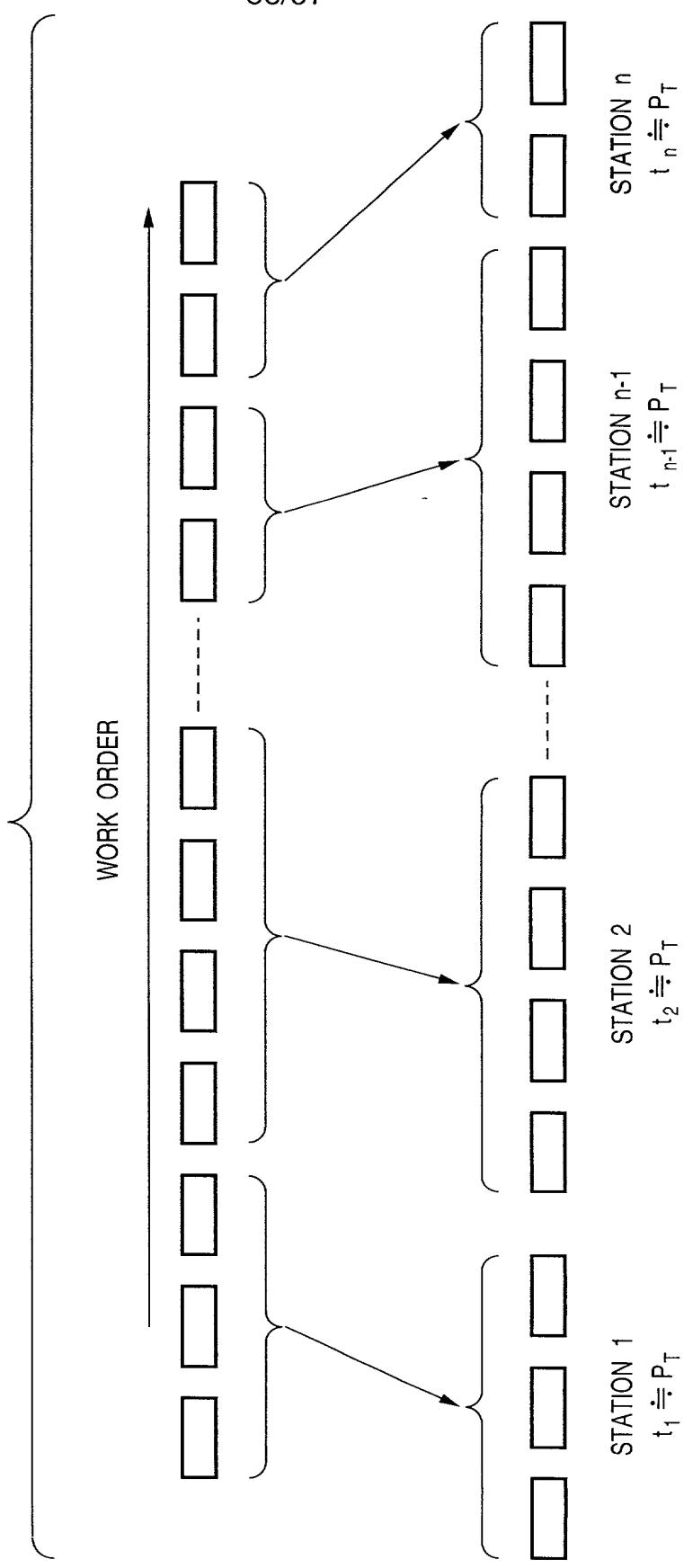
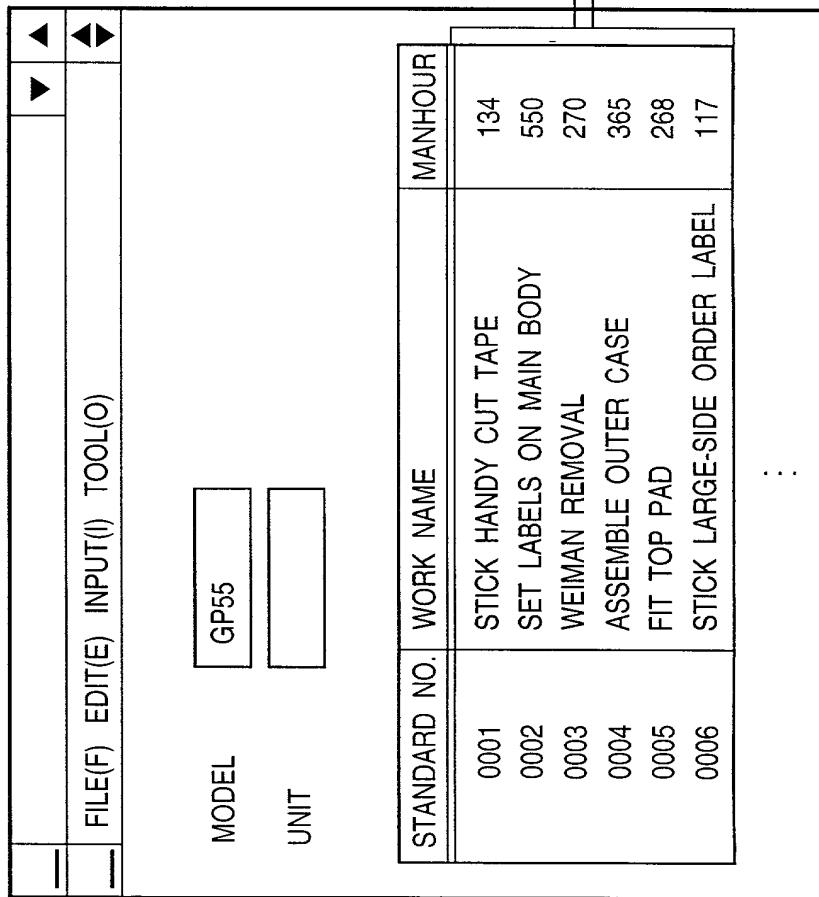


FIG. 66



## FIG. 67



The diagram illustrates a computer terminal screen with a menu bar and a data table. The menu bar includes FILE(F), EDIT(E), INPUT(I), TOCL(O), and a set of cursor keys. Below the menu is a table with columns for MODEL and UNIT, showing entries for GP55 and an empty box. To the right is a table of work standards with columns for STANDARD NO., WORK NAME, and MANHOUR. The table lists six entries, with the last two being continuation lines indicated by a colon. A bracket on the right side of the table groups the last two entries as 'PARALLEL DIVISION'.

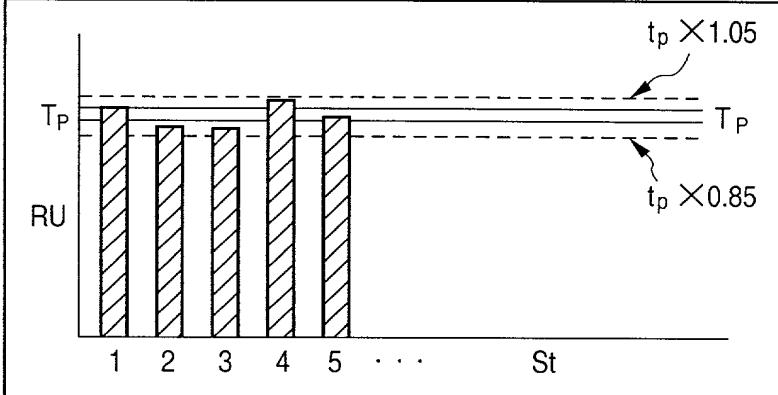
STANDARD NO.	WORK NAME	MANHOUR
0001	STICK HANDY CUT TAPE	134
0002	SET LABELS ON MAIN BODY	550
0003	WEIMAN REMOVAL	270
0004	ASSEMBLE OUTER CASE	365
0005	FIT TOP PAD	268
0006	STICK LARGE-SIDE ORDER LABEL	117
		:

**F I G. 68**

## SIMPLE DIVISION

		▼	▲
FILE(F) EDIT(E)		◆	◆
St 1			
0001	STICK HANDY CUT TAPE	134	
0002	SET LABELS ON MAIN BODY	550	
0003	WEIMAN REMOVAL	270	
St 2			
0004	ASSEMBLE OUTER CASE	365	
0005	FIT TOP PAD	268	
0006	STICK LARGE-SIDE ORDER LABEL	117	

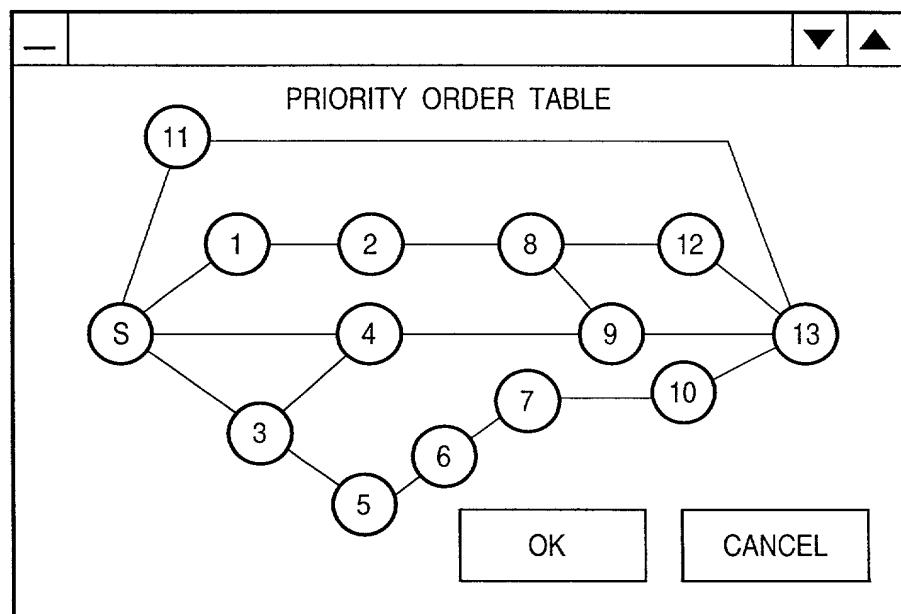
## FIG. 69

FILE(F)	EDIT(E)	▼	▲
COMPOSITION EFFICIENCY <span style="border: 1px solid black; padding: 2px;">92</span> %			
			
▼	▲	▼	▲

FILE(F)	EDIT(E)	▼	▲																		
<p>St 1</p> <table border="1"> <tr><td>0001</td><td>STICK HANDY CUT TAPE</td><td>134</td></tr> <tr><td>0002</td><td>SET LABELS ON MAIN BODY</td><td>550</td></tr> <tr><td>0003</td><td>WEIMAN REMOVAL</td><td>270</td></tr> </table> <p>St 2</p> <table border="1"> <tr><td>0004</td><td>ASSEMBLE OUTER CASE</td><td>365</td></tr> <tr><td>0005</td><td>FIT TOP PAD</td><td>268</td></tr> <tr><td>0006</td><td>STICK LARGE-SIDE ORDER LABEL</td><td>117</td></tr> </table> <p style="text-align: center;">DRAG AND DROP</p> <p>6902</p> <p>6903</p>				0001	STICK HANDY CUT TAPE	134	0002	SET LABELS ON MAIN BODY	550	0003	WEIMAN REMOVAL	270	0004	ASSEMBLE OUTER CASE	365	0005	FIT TOP PAD	268	0006	STICK LARGE-SIDE ORDER LABEL	117
0001	STICK HANDY CUT TAPE	134																			
0002	SET LABELS ON MAIN BODY	550																			
0003	WEIMAN REMOVAL	270																			
0004	ASSEMBLE OUTER CASE	365																			
0005	FIT TOP PAD	268																			
0006	STICK LARGE-SIDE ORDER LABEL	117																			
▼	▲	▼	▲																		
OK CANCEL		▼	▲																		

**FIG. 70**



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## FIG. 71

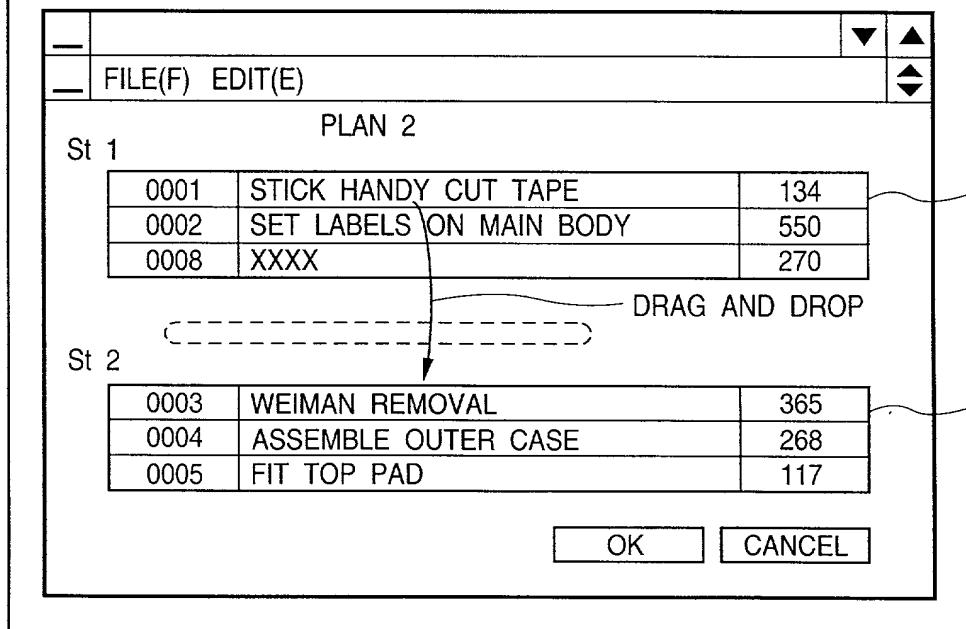
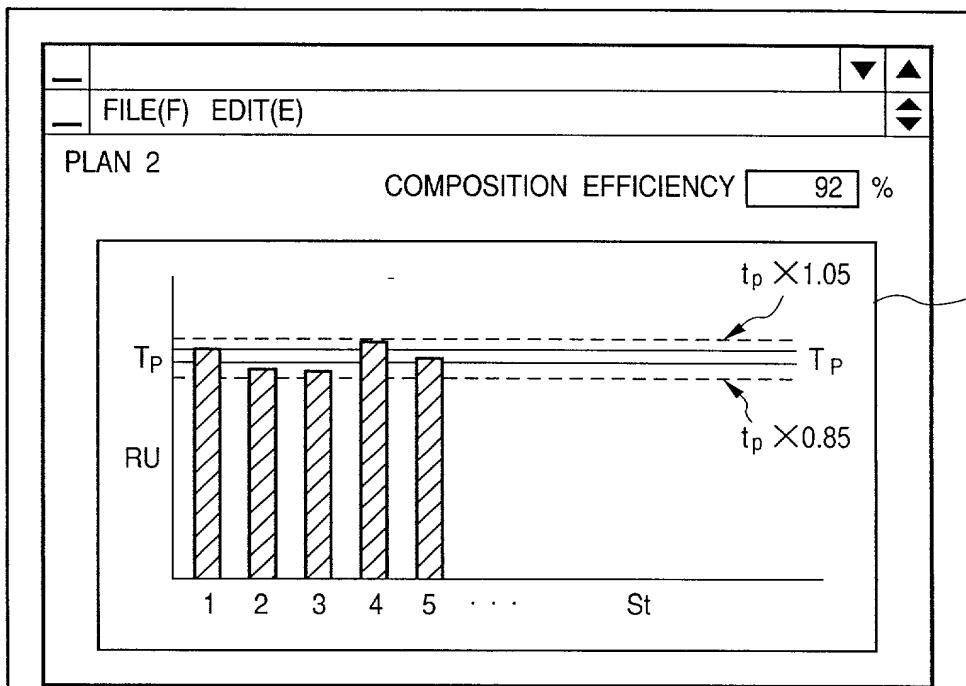
### PARALLEL DIVISION

PLAN 2		PLAN 1		
St 1		St 1		
1		1	STICK HANDY CUT TAPE	99
2		2	SET LABELS ON MAIN BODY	78
8		3	WEIMAN REMOVAL	134
St 2		St 2		
3		4	ASSEMBLE OUTER CASE	732
4		5	FIT TOP PAD	268
5		6	STICK LARGE-SIDE ORDER LABEL	117
				⋮

## FIG. 72

		<span style="font-size: 2em;">▼</span> <span style="font-size: 1.5em;">▲</span> <span style="font-size: 1.5em;">◆</span> <span style="font-size: 1.5em;">◆</span>									
<span style="font-weight: bold;">FILE(F) EDIT(E)</span>											
<span style="font-weight: bold;">PLAN 1</span> COMPOSITION EFFICIENCY <span style="border: 1px solid black; padding: 2px;">92</span> %											
<span style="font-size: 1.5em;">7201</span>											
		<span style="font-size: 2em;">▼</span> <span style="font-size: 1.5em;">▲</span> <span style="font-size: 1.5em;">◆</span> <span style="font-size: 1.5em;">◆</span>									
<span style="font-weight: bold;">FILE(F) EDIT(E)</span>											
<span style="font-weight: bold;">PLAN 1</span>											
St 1	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 10%;">0001</td> <td>STICK HANDY CUT TAPE</td> <td style="width: 10%;">134</td> </tr> <tr> <td>0002</td> <td>SET LABELS ON MAIN BODY</td> <td>550</td> </tr> <tr> <td>0003</td> <td>WEIMAN REMOVAL</td> <td>270</td> </tr> </table>	0001	STICK HANDY CUT TAPE	134	0002	SET LABELS ON MAIN BODY	550	0003	WEIMAN REMOVAL	270	<span style="font-size: 1.5em;">7202</span>
0001	STICK HANDY CUT TAPE	134									
0002	SET LABELS ON MAIN BODY	550									
0003	WEIMAN REMOVAL	270									
<span style="font-size: 1.5em;">DRAG AND DROP</span>											
St 2	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 10%;">0004</td> <td>ASSEMBLE OUTER CASE</td> <td style="width: 10%;">365</td> </tr> <tr> <td>0005</td> <td>FIT TOP PAD</td> <td>268</td> </tr> <tr> <td>0006</td> <td>STICK LARGE-SIDE ORDER LABEL</td> <td>117</td> </tr> </table>	0004	ASSEMBLE OUTER CASE	365	0005	FIT TOP PAD	268	0006	STICK LARGE-SIDE ORDER LABEL	117	<span style="font-size: 1.5em;">7203</span>
0004	ASSEMBLE OUTER CASE	365									
0005	FIT TOP PAD	268									
0006	STICK LARGE-SIDE ORDER LABEL	117									
<span style="border: 1px solid black; padding: 2px;">OK</span> <span style="border: 1px solid black; padding: 2px;">CANCEL</span>											

## FIG. 73



**FIG. 74**

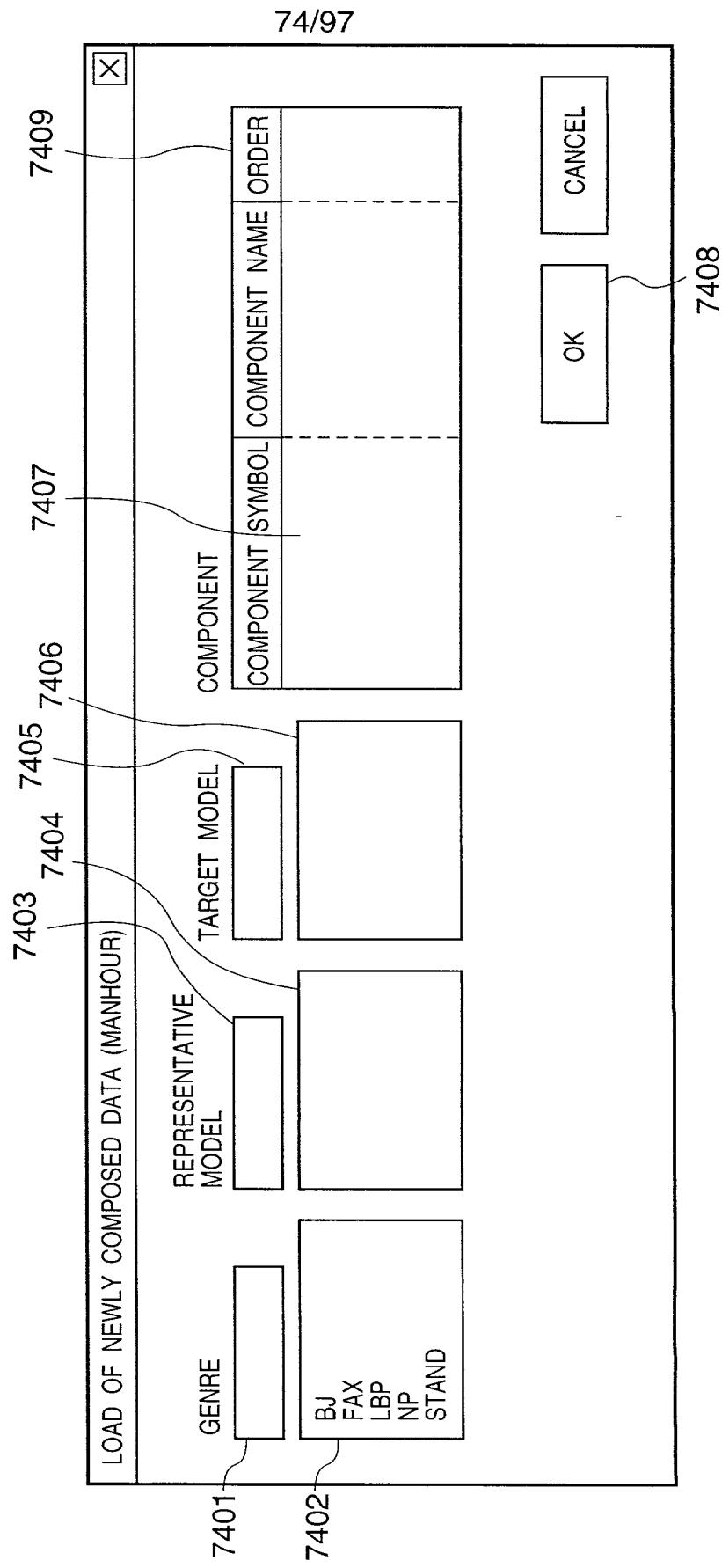


FIG. 75

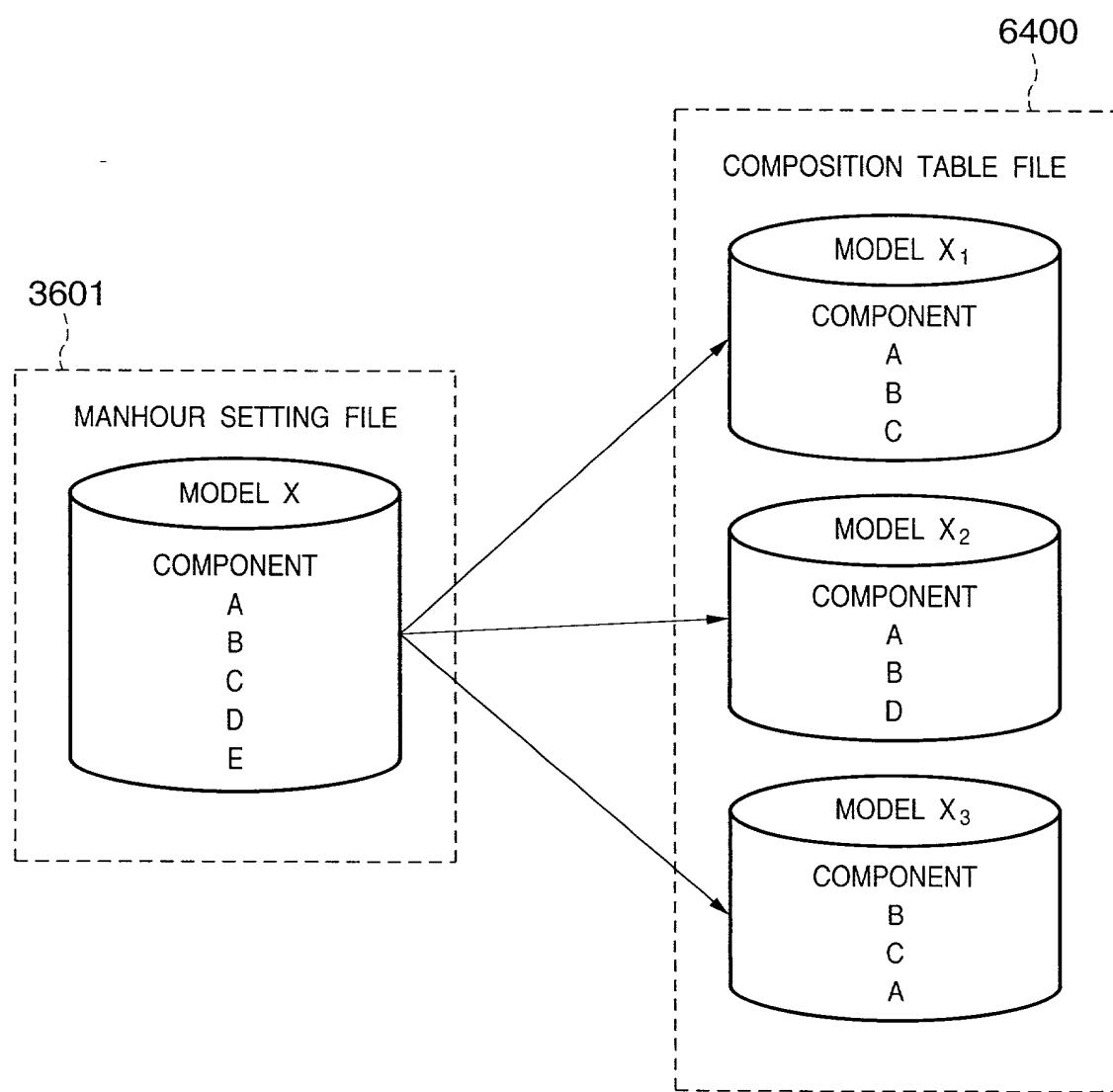
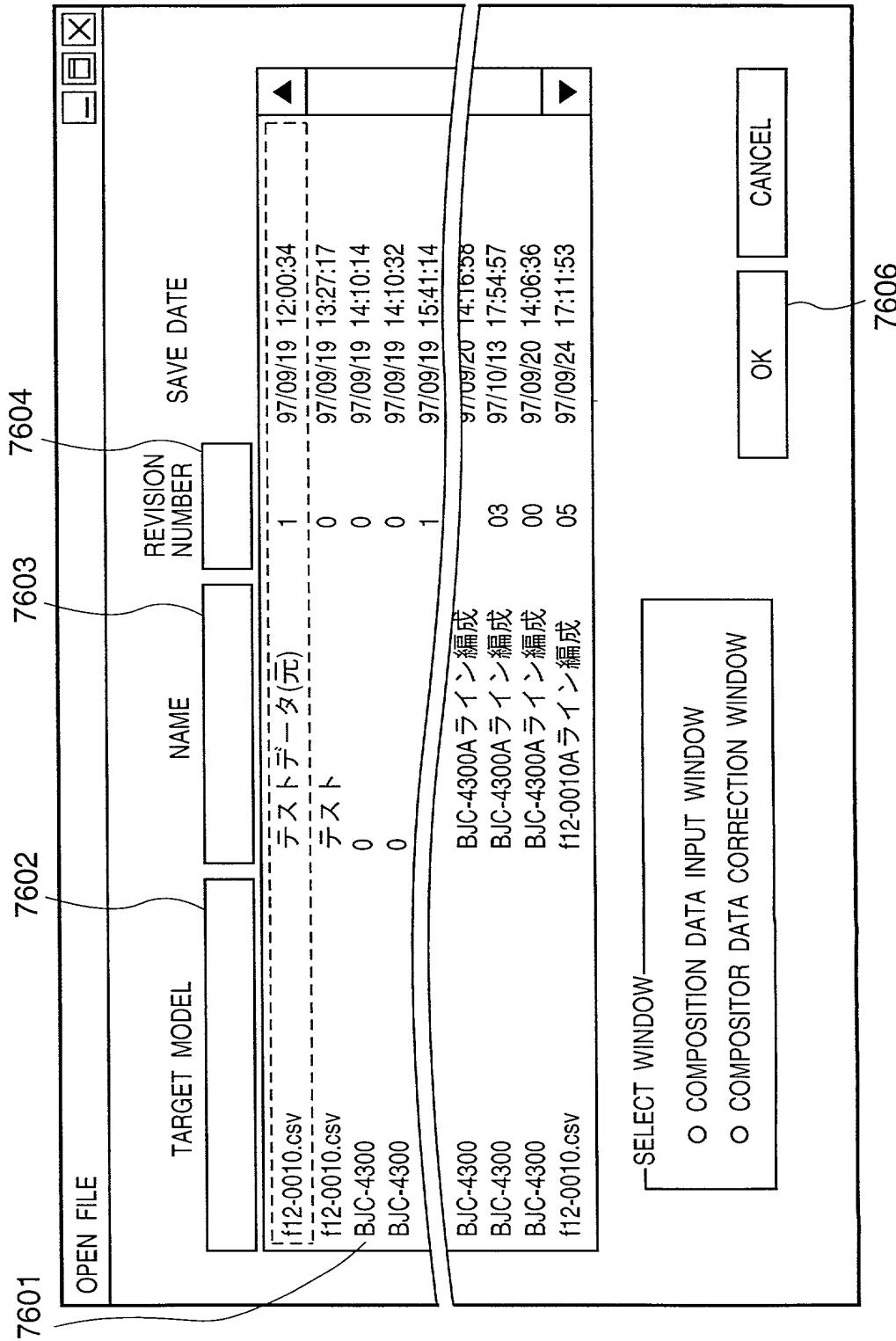
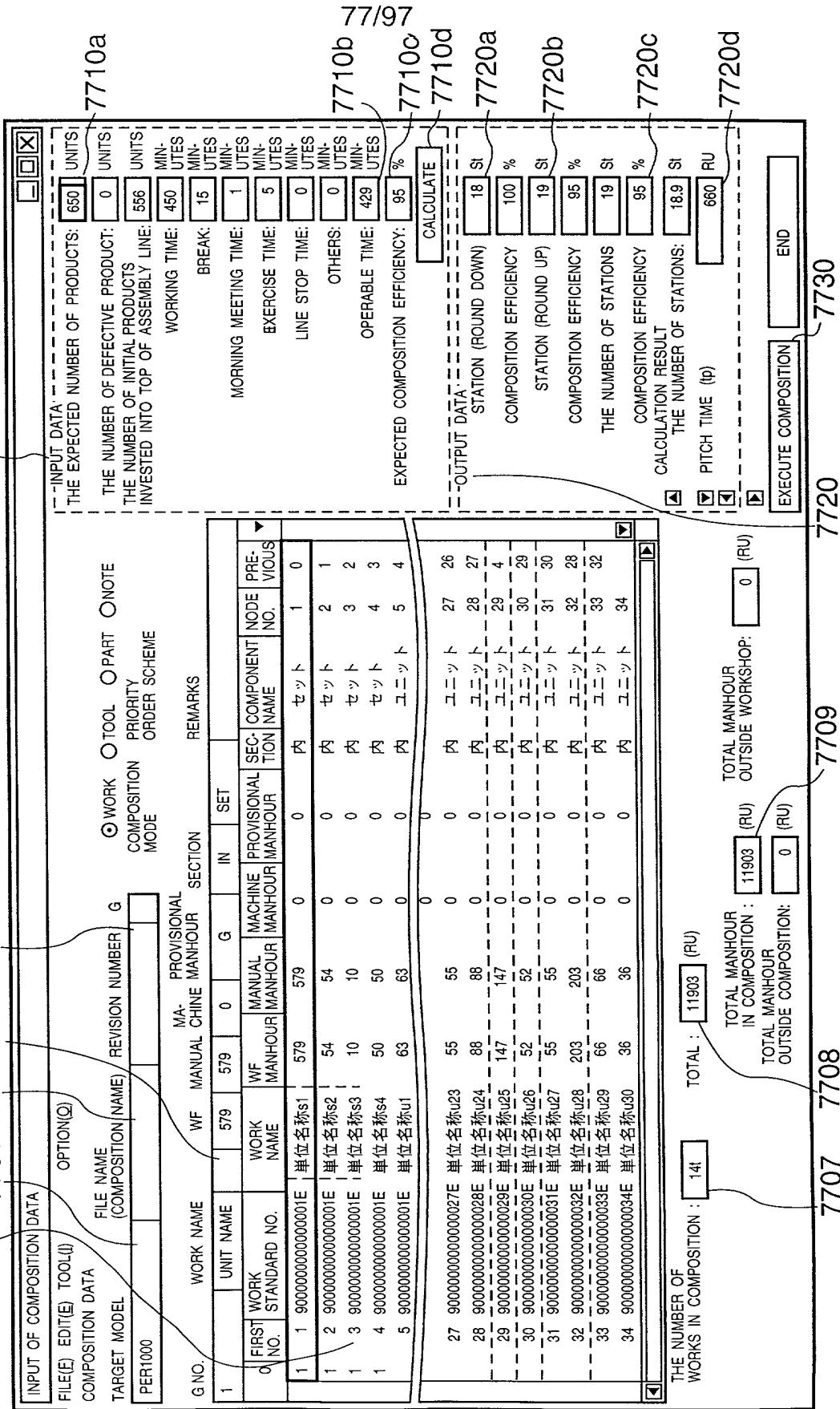


FIG. 76



## FIG. 77



## FIG. 78

7801

7802

INSERTION OF UNIT WORK	
<p>NEW WORK WILL BE INSERTED BEFORE "STICK CHECK SHEET SERIAL NO."</p>	
<p>INPUT WORK NAME AND PROVISIONAL MANHOUR VALUE</p>	
UNIT WORK NAME :	<input type="text"/>
PROVISIONAL MANHOUR :	<input type="text"/> (RU)
REMARKS :	<input type="text"/>
<p>OK      CANCEL</p>	

## FIG. 79

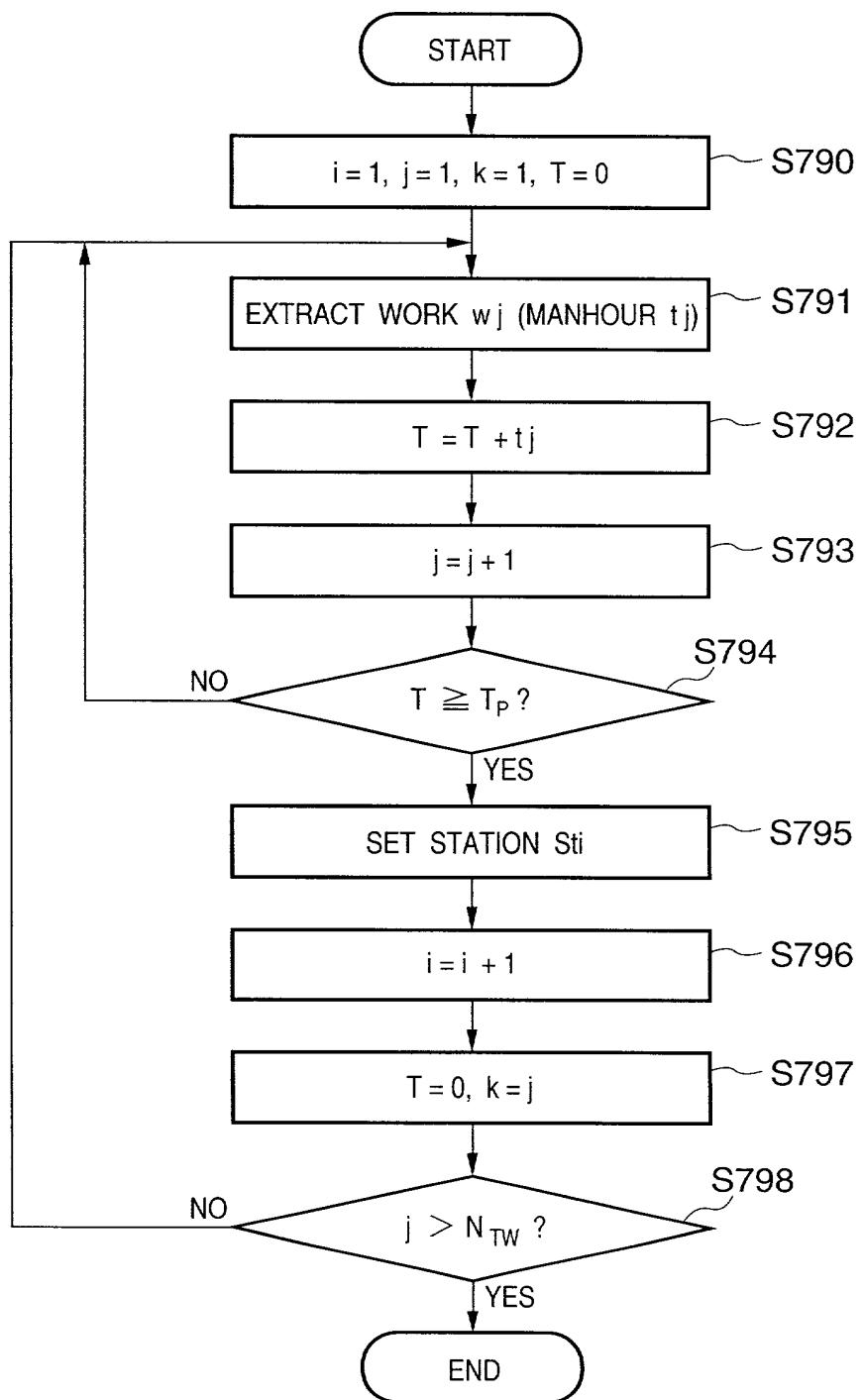
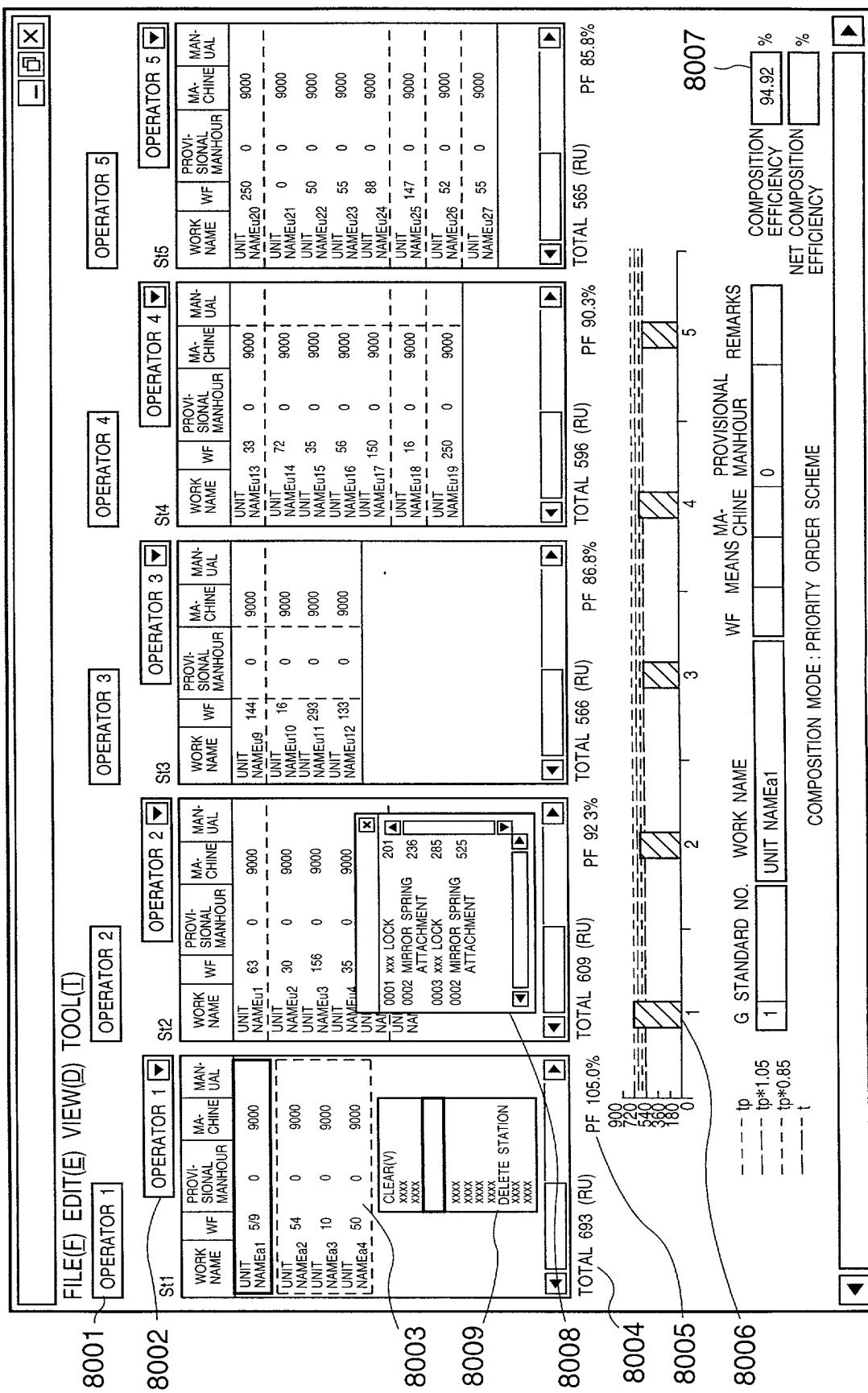


FIG. 80

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## F I G. 81

STATION 1

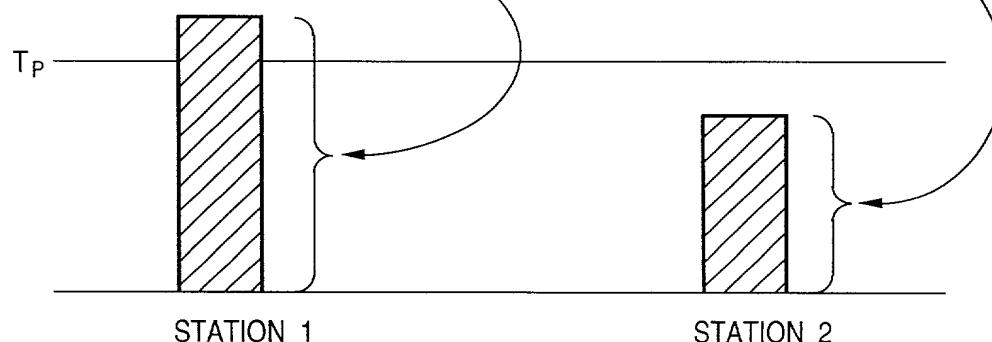
WORK NAME	MANHOUR
A1	10
A2	20
A3	12
A4	50

STATION 2

WORK NAME	MANHOUR
B1	10
B2	25
B3	11
B4	8

MANHOUR IN STATION = 92

MANHOUR IN STATION = 54



## F I G. 82

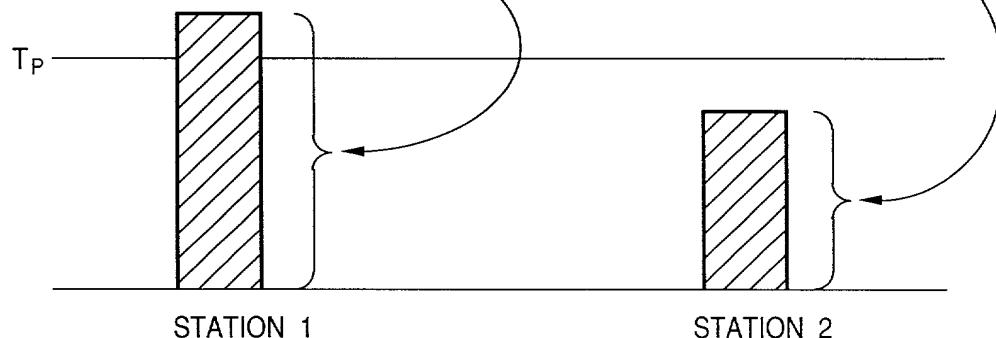
STATION 1

WORK NAME	MANHOUR
A1	10
A2	20
A3	12
A4 - 1	25
A4 - 2	25

STATION 2

WORK NAME	MANHOUR
B1	10
B2	25
B3	11
B4	8

MANHOUR IN STATION = 92



## FIG. 83

STATION 1

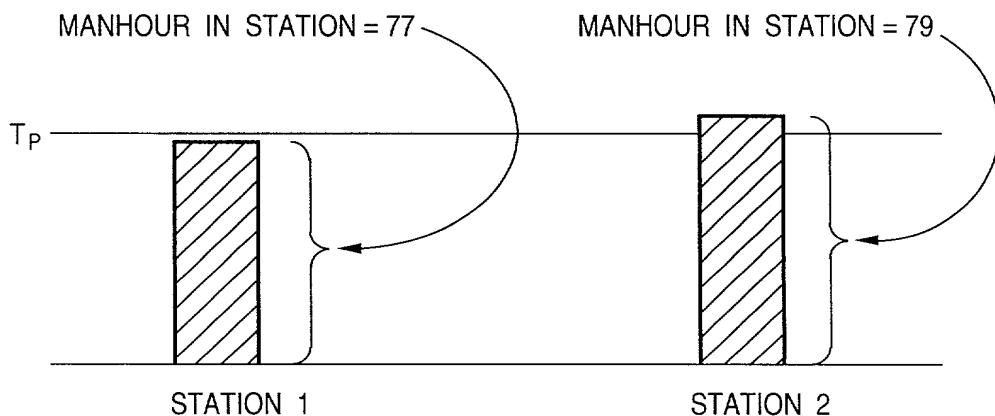
WORK NAME	MANHOUR
A1	10
A2	20
A3	12
A4 - 1	25

MANHOUR IN STATION = 77

STATION 2

WORK NAME	MANHOUR
A4 - 2	25
B1	10
B2	25
B3	11

MANHOUR IN STATION = 79



## FIG. 84

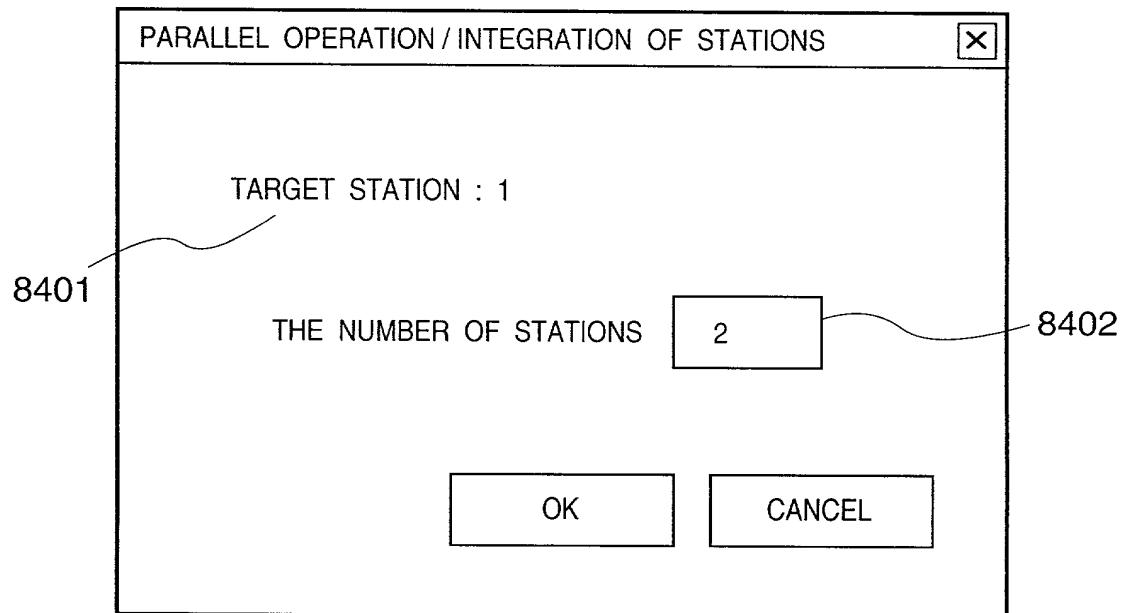
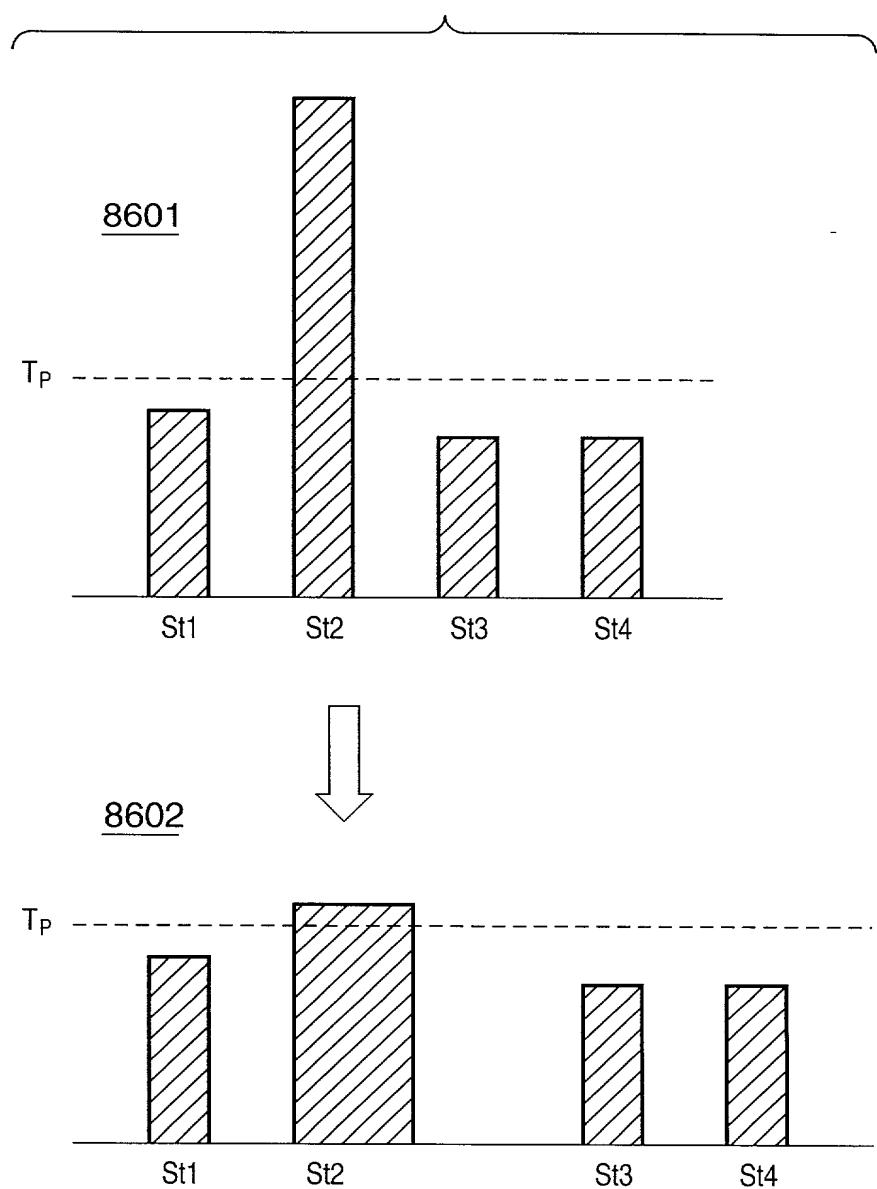


FIG. 85

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## F I G. 86

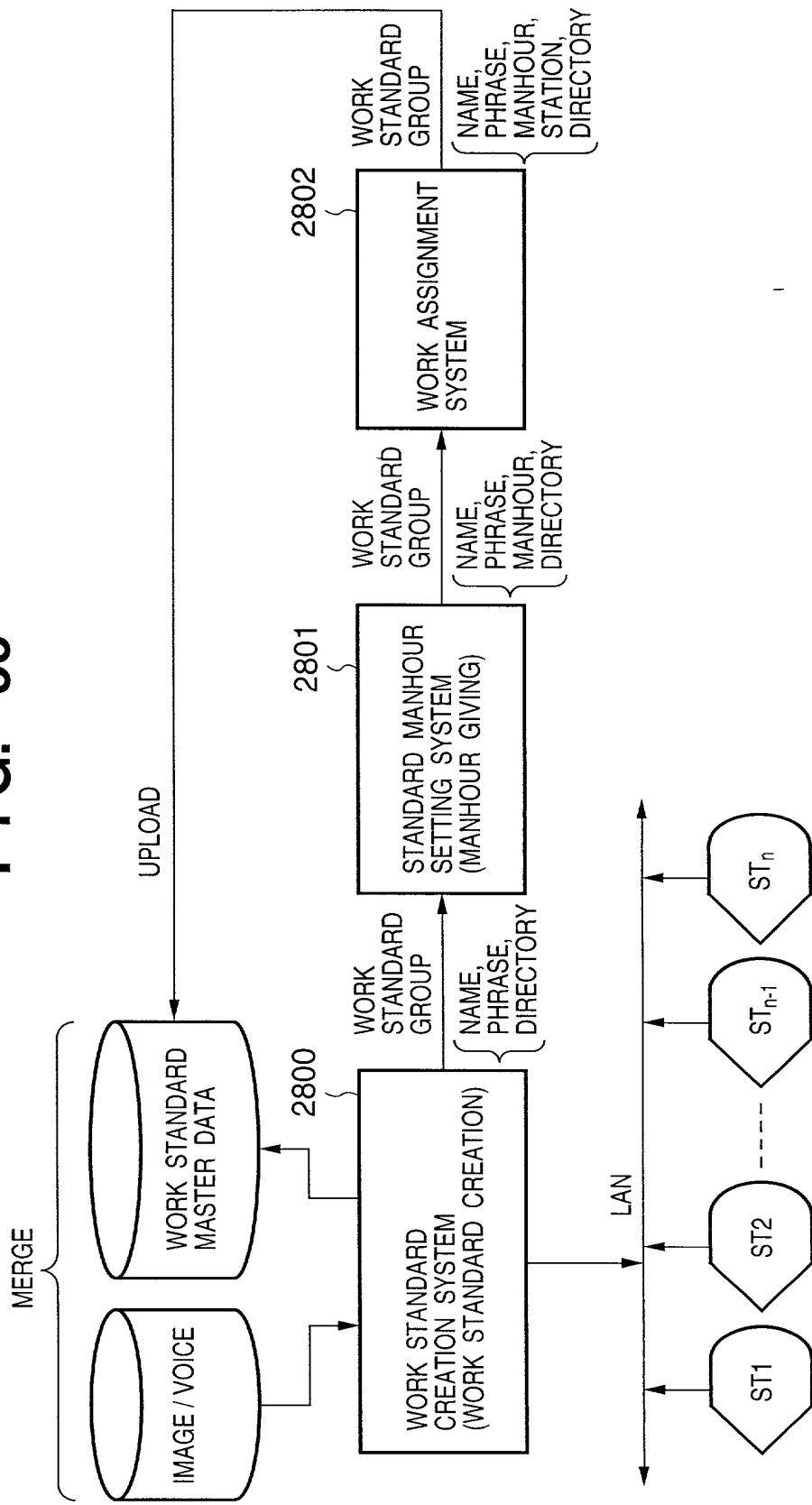


## FIG. 87

USER REGISTRATION	
NAME CODE :	12345
NAME :	田中 一郎
POSITION :	kumitate
PASSWORD :	12345
AUTHORITY :	
<input type="button" value="OK"/> <input type="button" value="CANCEL"/>	

8701  
8702  
8703  
8704  
8705

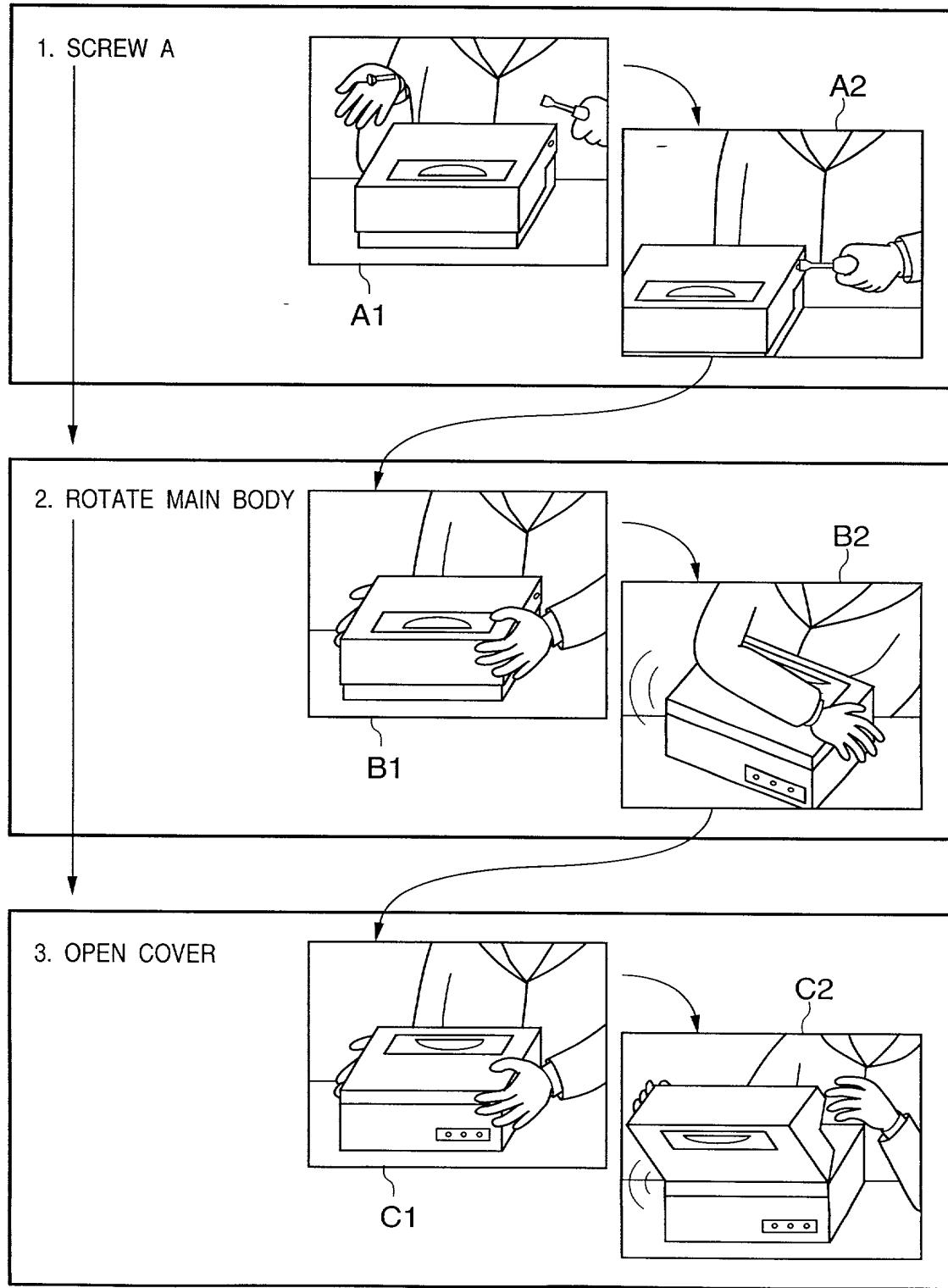
FIG. 88



# FIG. 89

DIRECTORY NAME	IMAGE DATA	OPERATION (VERB)	PARAMETER 1	PARAMETER 2	PARAMETER 3
xxxxxx1	SCREW	SCREW	SCREW CLOCKWISE	DISTANCE MOVEMENT 10mm	TORQUE 10Kg.M
xxxxxx2	SCREW	SCREW	SCREW CLOCKWISE	DISTANCE MOVEMENT 20mm	TORQUE 20Kg.M
xxxxxx3	SCREW	SCREW	SCREW CLOCKWISE	DISTANCE MOVEMENT 20mm	TORQUE 30Kg.M
...	...	...	...	...	...
yyyyyy1	ROTATE	ROTATE	CLOCKWISE	DISTANCE MOVEMENT 20mm	
yyyyyy2	ROTATE	ROTATE	COUNTERCLOCKWISE	DISTANCE MOVEMENT 20mm	
...	...	...	...	...	...
zzzzzz1	OPEN	OPEN	OPEN UPWARD	DISTANCE MOVEMENT 30mm	WEIGHT 100g
zzzzzz2	OPEN	OPEN	OPEN DOWNWARD	DISTANCE MOVEMENT 40mm	WEIGHT 200g
...	...	...	...	...	...

## FIG. 90

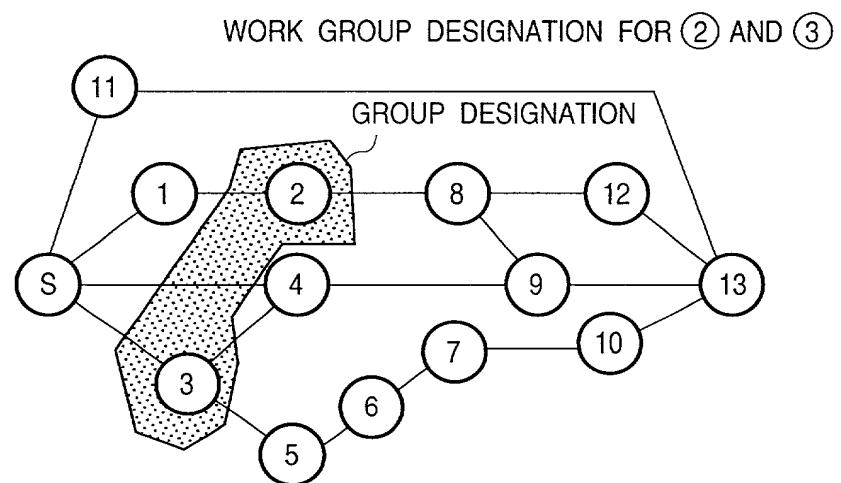


**F I G. 91**

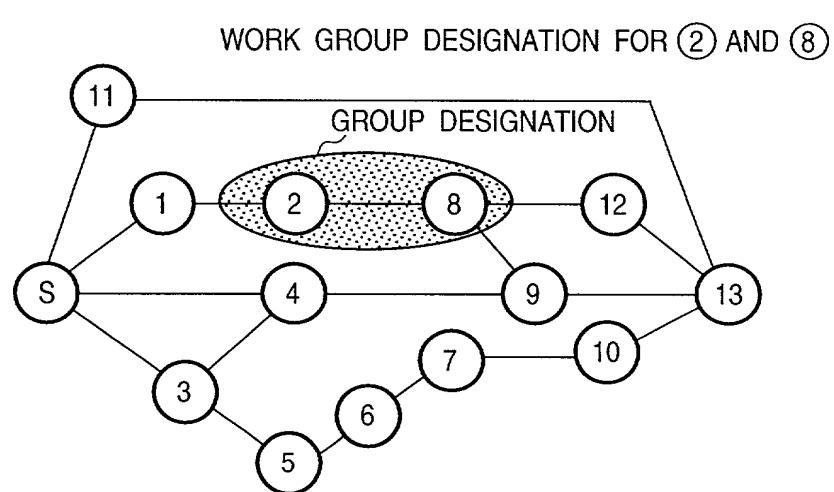
9101 9102

SETTING OF COMPONENT SYMBOL		
PRODUCT SYMBOL :	BJ - 970909	
COMPONENT SYMBOL :	CH	
COMPONENT NAME :	CHECK	
<input type="button" value="OK"/>	<input type="button" value="SEARCH COMPONENT"/>	<input type="button" value="CANCEL"/>

## FIG. 92



**FIG. 93**



**F I G. 94**

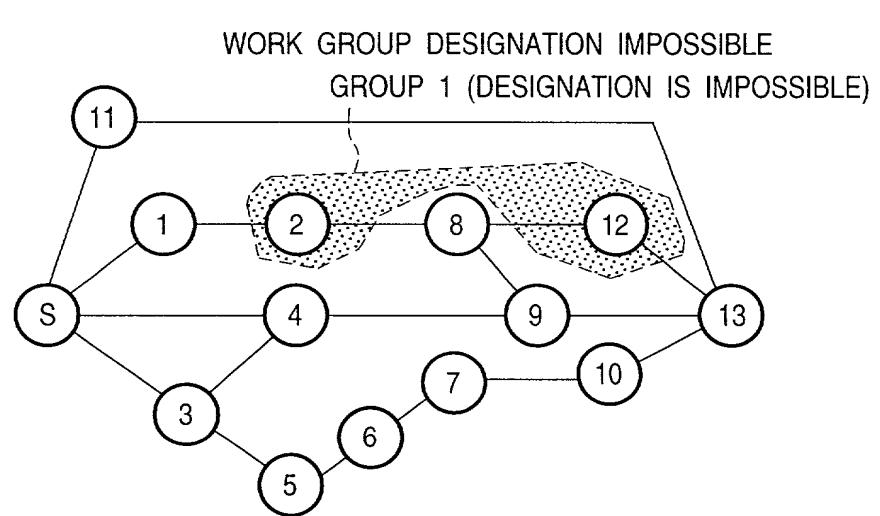
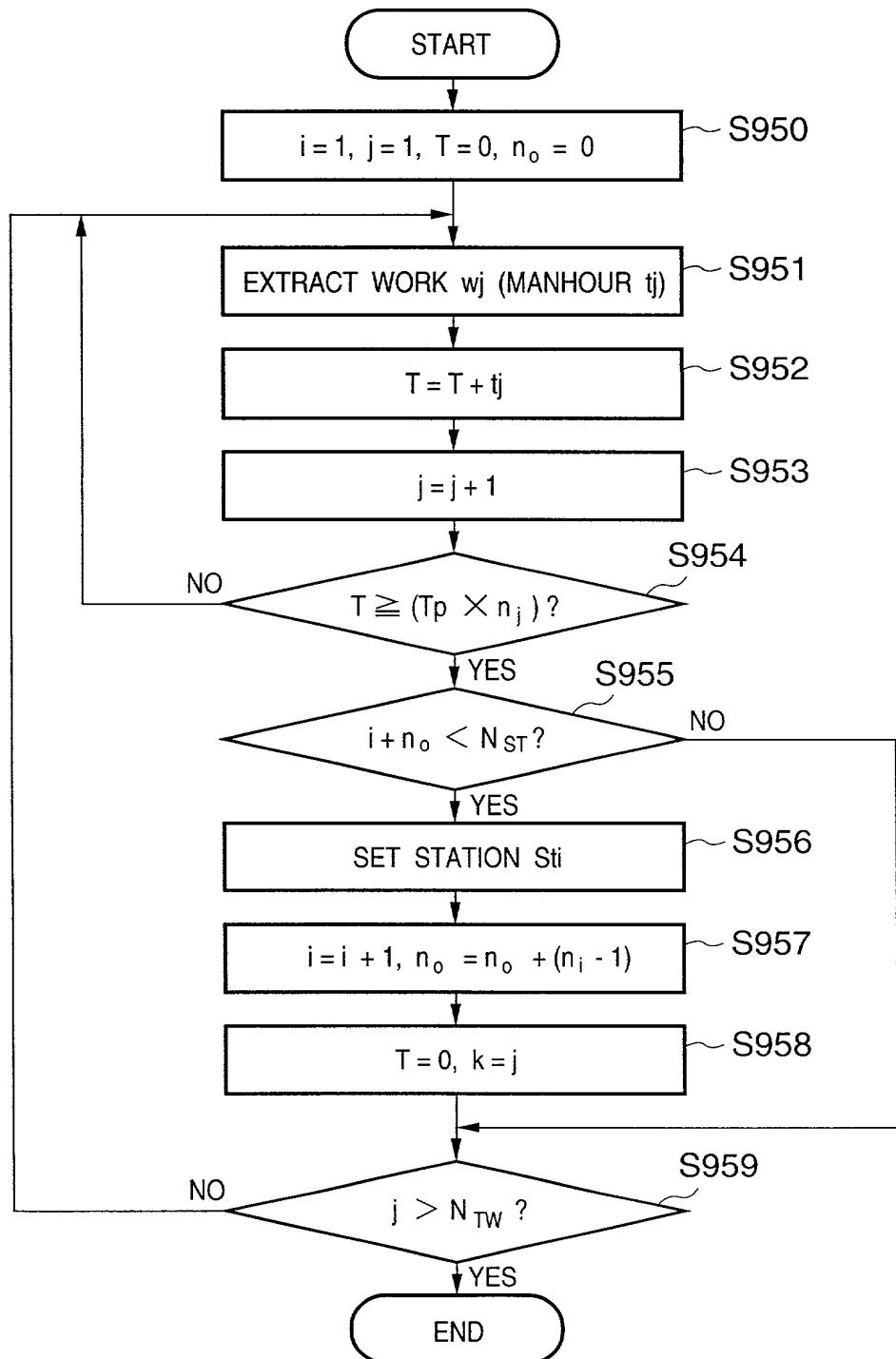
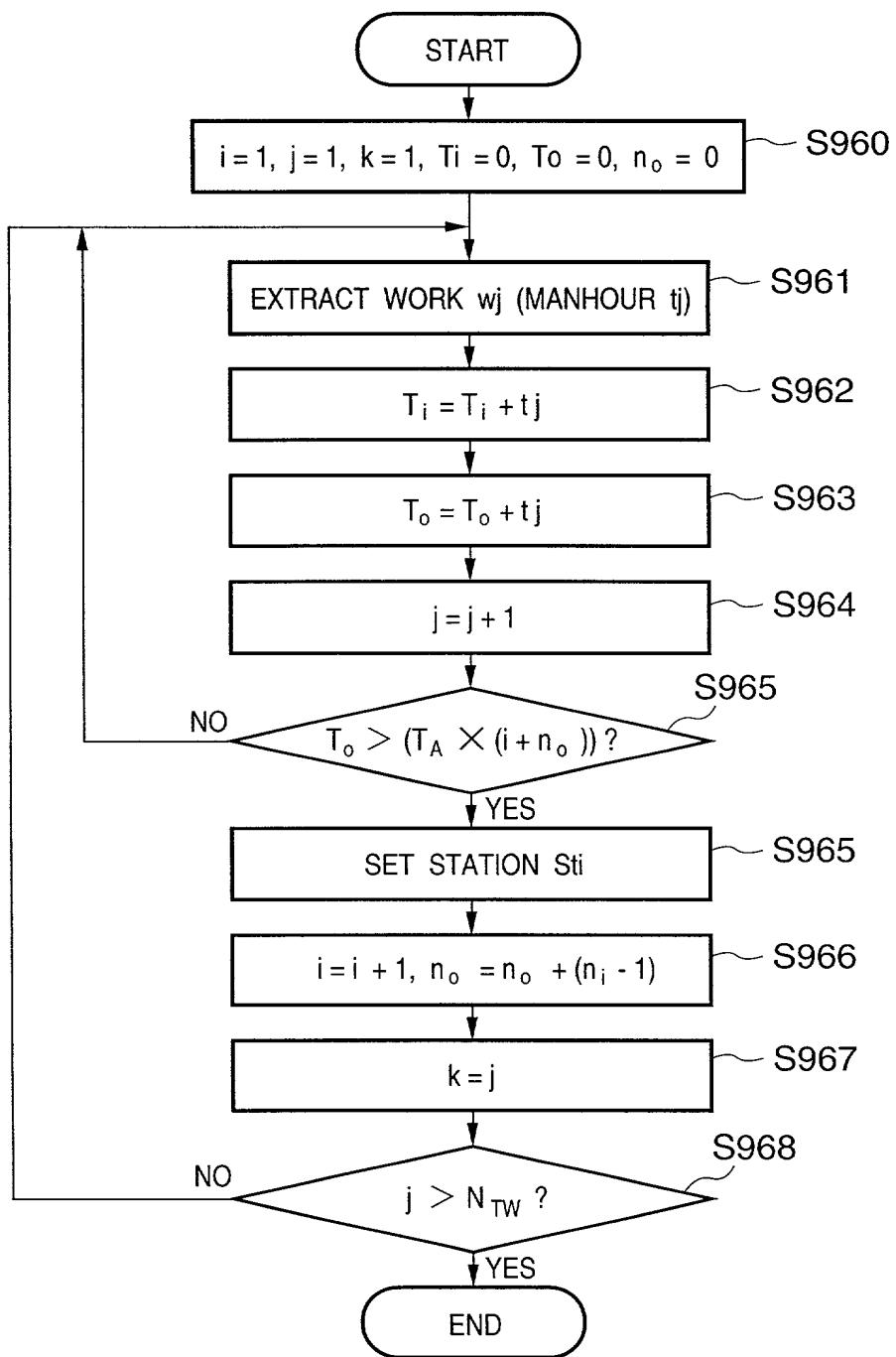


FIG. 95



$N_{ST}$ : THE NUMBER OF STATIONS  
 $n_i$ : i STATION PARALLEL NUMBER  
 $n_o$ : TOTAL ACCUMULATED PARALLEL SUM NUMBER

## FIG. 96



$N_{ST}$ : THE NUMBER OF STATIONS

$T_i$  : i STATION MANHOUR

$TA$  : STATION MANHOUR AVERAGE VALUE

$TA = WF / N_{ST}$

$To$  : TOTAL ACCUMULATED MANHOUR

$n_i$  : i STATION PARALLEL NUMBER

$n_o$  : TOTAL ACCUMULATED PARALLEL SUM NUMBER

# FIG. 97

